

Remarks Section

The newly amended claims and the new substitute specification represent the current status of the disclosure, which presents the integration of hydrocarbon conversion processes within double wall permreactors or permreactor-separator and permreactor-separator-reactor configurations. There is an inherent embodiment (integration) between the applied processes and processing permreactors or permreactor-separator configurations. The described processes are distinct because they can be practiced by another materially different reactor or reactor-separator system. As an example, the described hydrocarbon conversion processes can take place in a fixed bed impermeable catalytic reactor (of plug flow type). Also, the downstream gas separation can be performed by an adsorption or absorption process (instead of the membrane permeation or cryogenic separation process) in connection with the preceded reactor.

Both versions of the substitute specification are double spaced and with numbered paragraphs. A total of 75 paragraphs were included in both the old and the new substitute specification including the abstract of the disclosure. The title of the invention was also amended. The current substitute specification replaces the previous versions of specifications submitted on 3/14/00 and 9/18/01. Further, the current version of claims (claims 1-51) replaces (amends) all previous claims submitted on 3/14/00 and 9/18/01. The current amended process claims present distinct process steps that are sequentially performed.

The above changes were necessary because the previous version of the disclosure was incomplete. No new matter is included in the substitute specification. Though, some new examples describing the invention more thoroughly, were added in this last version of substitute specification which emphasize on the applications of the invention. These added embodiments together with the selected previous versions, make the invention to be described more completely and thoroughly.

With regard to the Figures (Drawings), the following changes are valid with respect to the original (previous, 3/14/01) specification:

A new Figure 2 replaces the previous Figure 2
A new Figure 3 replaces the previous Figure 3
A new Figure 4 replaces the previous Figure 4
A new Figure 5 replaces the previous Figure 5
An amended Figure 8 replaces the previous Figure 8
An amended Figure 11 replaces the previous Figure 11
A new Figure 12 replaces the previous Figure 12
A new Figure 13 replaces the previous Figure 13



Amendment by substitute specification

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Inventors: S. Vasileiadis,
Z. Ziaka-Vasileiadou

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"Version with markings to show changes made"

Deleted Matter is shown in brackets,

e.g., [membrane reactor]

Added matter is shown in bold letters

e.g., **permreactor and separator**,

TITLE OF THE INVENTION

**DOUBLE WALL PERMREACTOR [AND SEPARATOR] TYPE FUEL
PROCESSORS FOR PRODUCTION AND UTILIZATION OF HYDROGEN AND
[HYDROGEN, CARBON OXIDES MIXTURES] SYNTHESIS GAS**

Savvas Vasileiadis and

Zoe Ziaka-Vasileiadou

ZiVaTech Institute, 15549 Dearborn street, North Hills CA 91343, USA

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TECHNICAL FIELD

1 This invention relates to new process designs referring to double wall type [and reactor designs including] permeable reactors [(permreactors) and permeators] (so called **double wall permreactors or membrane reactors**) and to consecutive separators, including membrane type and cryogenic separators, for conducting mainly [for] the hydrocarbon steam reforming, hydrocarbon carbon dioxide reforming, combined hydrocarbon steam and carbon dioxide reforming, alcohol steam reforming, water gas shift, paraffin dehydrogenation, methanol synthesis, **methane oxidation**, and combination of these **carbon based** conversion reactions for the production of valuable upgraded fuels and chemicals. The invention [It] also relates to the utilization of the end reaction products such as pure hydrogen [,] and **synthesis gas** (hydrogen and carbon monoxide, hydrogen and carbon dioxide **mixtures**), and mixtures of these [species], into specific applications such as **consecutive** fuel cells, gas turbines, gas engines and synthesis reactors by application of uniquely presented process configurations.

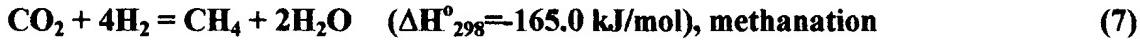
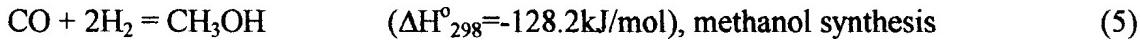
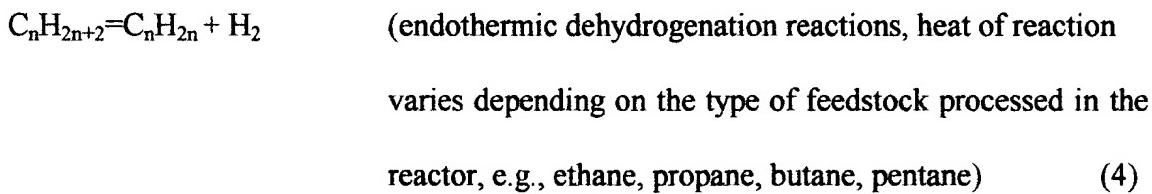
BACKGROUND OF THE INVENTION

2 [This current application is continuation in part of the application # 08/595040 filed 1/31/1996.]

The [This] current invention describes new and improved [process and reactor designs] processes which involve **double wall or multitube permeable reactors** (**multitube permreactors or membrane reactors**) and [permeators] downstream **separators (including pemreactors)** for the hydrocarbon steam reforming, hydrocarbon

carbon dioxide reforming, combined hydrocarbon steam and carbon dioxide reforming, alcohol steam reforming, the water gas shift reaction, dehydrogenation reactions of [hydrocarbons, such as dehydrogenation of alkanes (i.e., paraffins) to alkenes,] **alkanes (paraffins) and alcohols, hydrogenation reactions of alkenes to alkanes and of aldehydes, ketones to alcohols, methane oxidation**, and combination of these previous reactions.

3 The reactions and heats of reactions that are referred to and utilized within the embodiments of the invention are well known and are listed below:



Hydrogenation reactions of alkenes to alkanes, aldehydes to alcohols, and ketones to alcohols are the opposite of reactions (4), (10) and (11) respectively.

4 [These are catalytic reactions utilizing catalysts such as nickel (Ni), ruthenium (Ru), rhodium (Rh), palladium (Pd), platinum (Pt), chromium (Cr), copper (Cu), zinc (Zn), Cobalt (Co), Gold (Au) and other metals, and bimetallic catalyst compositions of these metals. The catalysts are supported on alumina (Al_2O_3), titania (TiO_2), silica (SiO_2), zirconia (ZrO_2), lanthanum (La_2O_3) and other supports, enriched with earth metals such as Ca, La, Na, K.]

The aforementioned are catalytic reactions utilizing active metals as catalysts in monometallic, bimetallic, or multimetallic metal compositions. The catalysts are supported on inorganic oxides such as on various types of alumina and enriched with earth metal additives to enhance catalytic activity and feedstock conversion and minimize deposition of carbon on active metal sites and loss of activity.

5 Use of [reactor and membrane permeator configurations] related processes involving catalytic reactor with downstream permeator configurations and systems of those were disclosed in our previous US patent [application: # 08/595040,] #6,090,312 (July 2000). Use of these reactor-separator systems increase the overall process efficacy by increasing the total conversion of [the following] feedstocks such as the following: natural gas, landfill gas, coal gas, hydrocarbons, hydrocarbons-CO₂ mixtures, methane, methane-CO₂ mixtures, alcohols. Moreover, the yields to hydrogen and carbon monoxide or hydrogen and carbon dioxide are increased by the use of the integrated membrane type permeators which [separates] separate effectively the H₂ and CO₂ [gases] gas constituents out of the reformed streams. Process efficiency is further

improved by the recycling of unreacted and non-separated (non-permeated) hydrocarbon (e.g., methane) and carbon monoxide into the first (primary) reactor (reformer) or the alternative direction of the same stream into a consecutive catalytic reactor (reformer or water gas shift reactor) for additional production of hydrogen and carbon dioxide. Direct utilization of the produced and separated hydrogen, synthesis gas, and hydrogen-carbon dioxide mixtures from these processes into consecutive synthesis reactors, fuel cells and gas turbines and engines are additional advantages and [continual] **continuing applications and utilizations** of the proposed processes.

6 [Current invention elaborates on the substitution of the primary conventional reactor (i.e., reformer, water gas shift, dehydrogenation reactor) by a permeable (membrane-type) reactor (so called permreactor for simplicity) of specific design, and the correspondingly derived improved process and permeable reactor-separator configurations for the above mentioned reactions. Moreover, introduction and specification of double wall permreactors, besides the single wall permreactors, for conducting similar reactions are also disclosed. The described permreactors are designed to consist of interconnected parts which can be readily taken apart and assembled when service is necessary. For the disclosed integrated reaction-separation systems specific applications are disclosed such as the utilization of the end products and/or permeated (separated) streams into consecutively placed synthesis reactors (including additional reformers or water gas shift reactors), gas turbines and engines, and various types of hydrogen based fuel cells and related fuel cell systems.]

Current invention and described processes elaborate on the substitution of the primary conventional reactor (i.e., reformer, water gas shift, dehydrogenation

reactor) by a permeable (membrane-type) reactor (so called permreactor for simplicity) of specific design, and the correspondingly derived improved process operations and permeable reactor-separator configurations for the above mentioned reactions. Moreover, the introduction and specification of double wall type membrane reactors (double wall permreactors) offer a variety of processes related to the above reactions which can be implemented accordingly as described below.

7 A specific problem in parallel gas separation and reaction within microporous membrane reactors (permreactors) is the lack of selective separation for the target compound (e.g., hydrogen) in certain materials. Thus, microporous inorganics, polymers, carbons and composites allow the permeation through the membrane of not only the targeted compound but also of other reaction products and reactants that compete for permeation based on their molecular diameter or molecular weight. This effect, separates in the permeate of the membrane reactor a stream which is not pure but needs further separation in order to be utilized as a pure compound (e.g., hydrogen for synthesis or fuel). Therefore, capital and operation costs are increased when a single wall membrane reactor of the above structure is to be used in the process. The introduced double wall permreactor solves this problem by applying a second consecutive membrane which only separates the targeted compound. For hydrogen separation as an example, a second metal or metal alloy membrane can be used, placed after the first microporous membrane, as described below.

8 The described permreactors are designed to consist of interconnected parts which can be readily taken apart, cleaned, serviced and assembled when service or

maintenance is necessary. For the disclosed integrated reaction-separation systems specific applications are disclosed such as the utilization of the end products and/or of the permeated (separated) streams into consecutively placed synthesis reactors (including additional reforming or water gas shift reactors), gas turbines and engines, and various types of hydrogen and methanol based fuel cells and fuel cell systems.

9 [Previous reactor and permeable reactor designs from the above cited references refer mainly to methane and methanol steam reforming reactions but not to carbon dioxide reforming, water gas shift and dehydrogenation reactions as the present invention does. Moreover, previous inventions refer to a single reactor or permreactor or other reaction vessel instead of reactor-separator systems as the present invention describes. Present invention introduces double permeable-wall (double membrane-wall) reactors for hydrocarbon and alcohol processing reactions. The double membrane-wall reactors can be of various designs as disclosed within the embodiments of the invention. These can be catalytic reactors as adapted to specific process requirements in terms of setting key operating variables such as reaction temperature, pressure, space velocity, feed composition, to deliver final products (i.e., hydrogen and synthesis gas) in the purity and throughput required by consecutive applications. Moreover, flexibility in the selection of permreactor wall materials such as metals, inorganics, organics and composites, allows design of multifunctional permeable reactors which separate and deliver specific species (e.g., gases) with the required purity and throughput to consecutive applications. Flexibility in the selection of functional and specific permreactor wall materials for each process operation have also economic advantages. Current disclosed permreactor,

separator, and overall process designs can utilize membrane materials selected from classes of metals, inorganics (non-porous or porous), polymers, carbons and carbonaceous materials, and composites. Therefore, the selection of less expensive membrane materials for a specific permreactor, permeator and process operation is available with current invented designs.]

Previous reactor and permeable reactor (membrane reactor) designs from the above cited references refer mainly to methane and methanol steam reforming reactions but not to carbon dioxide reforming, water gas shift and dehydrogenation reactions as the present invention also does. Moreover, previous inventions refer to processes occurring within a single reactor or permreactor or other reaction vessel instead of reactor-separator systems as the present invention describes. Present invention introduces processes which are based on double wall permeable reactors (double wall membrane reactors) for conducting mainly hydrocarbon and alcohol catalytic processing reactions. The double wall membrane reactors can be of various designs and be made by various appropriate materials as disclosed within the embodiments and claims of the invention. The catalytic reactors are adapted to specific process requirements in terms of setting values of key operating variables such as reaction temperature, pressure, space velocity, feed composition, catalyst composition and weight, in order to deliver final products (such as hydrogen and synthesis gas) in the required purity and throughput for the consecutive applications. Selection of such variables like temperature, pressure, and feed composition in the different compartments of the described membrane reactor system is also of significant importance. This is because an interconnection and

synergetic activity between the various compartments occurs during operation with reaction and separation operations to occur at the same time. Moreover, flexibility in the selection of the double wall permreactor materials such as metals, inorganics, organics and composites, allows for the design of such multifunctional permeable reactors which separate and deliver specific species (such as specific gases) with the required purity and throughput to the consecutive applications. Flexibility in the selection of functional and specific permreactor wall materials for each process operation have also economic advantages. Current disclosed permreactor and separator vessels can utilize membrane materials selected from various classes of metals, inorganics (porous or non-porous), polymers, carbons and carbonaceous materials, and composites. Therefore, the selection of less expensive membrane materials and manufacturing techniques for a specific permreactor, permeator and overall process is available with the current invented designs and will affect (reduce) the cost of the overall process operation.

10 Present invention also teaches the direct utilization of end product streams to consecutive synthesis reactors, fuel cells, gas turbines and gas engines. Use of such low pollution energy systems with increased efficiency is of updated interest in utility, energy, chemical, refinery, automobile and environmental companies. Present invention focuses on converting and upgrading primary hydrocarbon feedstocks such as methane, natural gas, coal gas, refinery feedstocks such as naphtha, [and] alcohol feedstocks such as methanol, [and] ethanol and higher alcohols into [to] higher calorific value hydrogen and carbon oxide mixtures[;]. Also [also] it focuses on converting secondary, flue, and waste hydrocarbon feedstocks such as acidic natural gas, biomass

gas, flue gas rich in CO₂ and CH₄ to the same valuable end products. Therefore, present invention describes environmentally benign [reactor designs and process designs] processes which abate and upgrade at the same time, among other feedstocks, otherwise waste gases to valuable hydrogen, synthesis gas, and hydrogen, and carbon dioxide mixtures. The [In] in situ conversion of carbon dioxide containing hydrocarbon mixtures to alternative fuels and chemicals including hydrogen, and the subsequent mitigation [abatement] of the carbon dioxide negative atmospheric and terrestrial greenhouse effects [can be] are considered [an] additional benefits from the implementation of [the] this invention.

SUMMARY OF THE INVENTION

11 [The present invention discloses double wall permeable reactors and the related elaborate reactor designs, which offer operational advantages by conducting in-situ reactions, in comparison with single wall permeable reactors and conventional non-permeable reactors. Consequently, three different permeable reactor configurations are disclosed. These reactor designs are applied to catalytic hydrocarbon and alcohol reforming, water gas shift and hydrocarbon dehydrogenation reactions. The first design is a double wall permreactor which consists of three concentric hollow cylindrical tubes with the two inner ones to be made by permeable metal, inorganic, carbon or polymer materials depending on the type of feedstocks used and the desired composition of final exit streams. Heating tubes run through the most-inner cylinder which is also filled with the main reaction catalyst. Similarly, the second reactor design consists also of three concentric hollow cylindrical tubes with the two inner ones to be made by permeable

metal, inorganic, carbon or polymer materials but with the main reaction catalyst to be contained in the annular space between the most-outer and the next-inner tubes. Heating in this design is achieved by heating the external side of the most-outer tube. Third reactor design consists of an outer impermeable tube which nests multiple organic polymer or composite polymer tubes for gas permeation. Outer tube contains also the main reaction catalyst which is located around the polymer tubes. Heating is achieved by external heating of the outer tube.]

The present invention discloses processes which consist of double wall permeable reactors (permreactors) and systems of such advanced reactors with consecutively placed separators to perform specific process operations. These integrated chemical-mechanical systems offer operational advantages by conducting in-situ reactions, in comparison with single wall permeable reactors and conventional non-permeable reactors. Consequently, different double wall permreactor processes are disclosed. These are used in catalytic hydrocarbon and alcohol reforming, water gas shift, hydrocarbon and alcohol dehydrogenation and hydrogenation reactions. The first process comprises of a double wall permreactor which incorporates three concentric hollow cylindrical tubes with the two inner ones to be made by permeable (and permselective) metal, inorganic, carbon, polymer or composite materials depending on the type of feedstocks used, the reactions and reaction conditions occurring, and the desired composition of the final exit streams. Heating tubes run through the most-inner cylinder which is also filled with the main catalyst to conduct the appropriate reaction. Additional catalyst can be placed in the

two outer annular spaces created between most-outer and next-inner and between next-inner and most-inner tubes. By varying the catalyst position and catalyst type this process can be applied to a number of different reactions. Similarly, the second process involves a double wall permreactor which consists of three concentric hollow cylindrical tubes with the two inner ones to be made by permeable (permselective) metal, inorganic, carbon, polymer or composite materials and with the catalyst for the main reaction to be contained in the annular space between the most-outer and the next-inner cylindrical tubes. Heating in this process is applied into the external side of the most-outer tube. By applying catalyst at the different annular spaces created between the concentric tubes, this process can be applied to various reactions. In both processes, the metal based membranes can act also as catalysts for the reactions occurring in the different zones. The two processes differ in the heat and mass transfer profiles and distribution across the radial distance and along the axial distance. Use of the described advanced permreactor processes offer significant increases in conversion of reactants and increases in yield and selectivity of products. This is achieved via improved mass and heat transfer, and improved reaction rates within the defined reactor (and catalyst) parts of the process as described above. Also, the effect of removing products out of the defined reaction zones during the reaction, increases the reactant conversion and the yield to useful products by shifting the equilibrium of the occurring reactions to the product side. Further, use of the described permreactors allows for systems of reactions to take place and be combined in the same module. Synergetic effects of utilizing products

and/or reactants of these reactions to conduct improved processes in a consecutive or/and parallel manner is also a result of this invention.

12 [Moreover, the invention pertains to systems of the described permeable reactors with consecutive permeators for separation and further processing of post-reaction gases exiting from the reactors. Permeators can be made by polymer membranes for the concomitant separation of hydrogen and carbon dioxide gases or by metal, non-porous inorganic and carbon membranes for the separation of hydrogen only. These permreactor-permeator systems are applied to combined hydrocarbon steam and carbon dioxide reforming, hydrocarbon steam reforming, hydrocarbon carbon dioxide reforming, alcohol steam reforming, water gas shift and paraffin dehydrogenation reactions for increasing the reactant conversion and the yield to hydrogen, carbon monoxide and carbon dioxide. The separated hydrogen and carbon oxides are used in further chemical synthesis reactions and as fuel in fuel cells, gas turbines and gas engines. The invention also includes hydrocarbon-CO₂-steam reforming systems of permreactors with cryogenic separators wherein the consecutive permeators are replaced by cryogenic separators and pure hydrogen and carbon monoxide are recovered as final products. Similar permreactors are also directly interconnected with solid oxide fuel cells for use of the products hydrogen, carbon monoxide and steam as direct fuel in the anode of the cell. Finally, the invention includes use of the disclosed permreactors in series with methanol synthesis and methanol reforming reactors for final production of methanol, hydrogen and carbon dioxide for use as synthesis chemicals or fuels. Detailed description of the invention are presented in the embodiments of the following Figures.]

Moreover, this invention pertains to combined processes of the described permreactors with consecutive permeators for the further separation and processing of the post-reaction gases exiting from the permreactors. Permeators can be made by polymer membranes or by metal, inorganics, carbon and composite membranes for the concomitant separation of hydrogen and carbon dioxide gases, or for the separation of hydrogen only. These permreactor-permeator systems are applied to combined hydrocarbon steam and carbon dioxide reforming, hydrocarbon-steam reforming, hydrocarbon-carbon dioxide reforming, alcohol steam reforming, water gas shift, paraffin dehydrogenation, hydrocarbon or aldehyde or ketone hydrogenation reactions and methane oxidation. The processes are capable to increase the reactant conversion and the yield to hydrogen, carbon monoxide, and carbon dioxide. The separated hydrogen and carbon oxides can be used in consequent chemical synthesis reactions and as fuel in fuel cells, gas turbines and gas engines. The invention also includes hydrocarbon-CO₂-steam reforming process which consists of permreactors with cryogenic separators wherein the consecutive cryogenic separators replace the permeators, and a pure mixture of hydrogen and carbon monoxide is recovered as a final product. Similar permreactors as described above are directly interconnected with solid oxide and molten carbonate fuel cells for using the products hydrogen, carbon monoxide and the unreacted steam as direct fuel in the anode of the cell. Further, the invention includes use of the disclosed permreactors in series with methanol synthesis reactors for final production of methanol and use as fuel or synthesis chemical.

13 Further, the invention describes dehydrogenation reactions occurring in the middle annular space combined with the hydrogen permeation in the radial direction of the reactor via the enclosed membranes and the reaction of permeate hydrogen with another compound in the adjacent sides of the reactor to yield a new chemical compound, with the enclosed metal membranes to be used also as catalysts for the reactions. Such dehydrogenation reaction in the middle annular space is combined with hydrogenation of aldehydes or ketones to alcohols and hydrogen reduction reactions in the adjacent spaces such as hydrocracking reactions of higher paraffins to yield lower paraffin and olefin products in a beneficial manner. Finally, a related methane oxidation process is disclosed which uses oxygen transporting membranes to deliver oxygen into adjacent flowing methane streams for partial oxidation reactions which produce synthesis gas (hydrogen and carbon monoxide). Detailed description of the invention are presented in the embodiments of the following Figures.

BRIEF DESCRIPTION OF THE DRAWINGS

14a Fig.1, shows a vertical [the] cross [section] sectional view of a concentric double [permeable] wall cylindrical process [reactor] permreactor for related processes, with tubular type heaters located along the catalyst zone, consisting of an inner metal, non-porous or porous inorganic, or [carbon] composite membrane tube and an outer membrane tube made by metal, non-porous inorganic, [carbon] composite or high temperature polymeric [organic] membrane enclosed within a far-outer impermeable tube.

14b [Fig.2, shows multiple double permeable wall reactors of those described in Fig.1, but without the external impermeable tube, which are placed symmetrically inside a larger common stainless steel tube, to create a multiple tube reactor with a common external area for collecting final permeate hydrogen.]

Fig.2, shows a sectional view of the same process permreactor as in Fig.1, including the three catalyst beds, the two cylinder type inner and outer membrane tubes, the inner axial heating elements, and the inlet and outlet ports in each section of the permreactor.

14c [Fig.3, shows a cross section of a concentric double permeable wall cylindrical reactor, consisting of an outer impermeable tube, a next-inner membrane tube made by metal, non-porous or porous inorganic, or carbon membrane, and a most-inner membrane tube made by metal, non-porous inorganic, carbon or organic membrane.]

Fig.3, shows multiple double wall process permreactors of those described in Fig.1, but without the external impermeable tube, which are placed symmetrically inside a larger common impermeable metal tube, to create a multiple tube permreactor with a common external area for collecting final permeate hydrogen.

14d [Fig.4, shows multiple double permeable wall cylindrical reactors of those described in Fig.3, which are placed symmetrically inside a larger stainless steel tube, to create a multiple tube reactor with a common external heating area.]

Fig.4, shows a cross section of a similar concentric double wall process permreactor, consisting of an outer impermeable tube, a next-inner membrane tube made by metal, non-porous or porous inorganic, or composite membrane, and a

most-inner membrane tube made by metal, non-porous inorganic, composite or high temperature polymeric membranes.

14e [Fig5., shows a cross section of a multiple permeable membrane tube reactor wherein the membranes are made by an organic or composite polymer and are nested within an outer impermeable tube.]

Fig.5, shows multiple double wall process permreactors of those described in Fig.4, which are placed symmetrically inside a larger impermeable metal tube, to create a multiple tube permreactor with a common external heating area.

In the Figures below, the permreactors are as those described in Fig.1, Fig3, Fig.4 or Fig.5 above.

14f [Fig.6, shows a system of a catalytic permreactor and a consecutive permeator or optionally a system of two catalytic permreactors in series for hydrocarbon steam and CO₂ reforming or for hydrocarbon CO₂ reforming only. The reject from the permeator stream containing non-permeate hydrocarbon and CO can be optionally fed into a consecutive catalytic steam reforming reactor.]

Fig.6, shows a combined process which includes a catalytic permreactor and a consecutive permeator or optionally a process of two catalytic permreactors in series for hydrocarbon or alcohol steam and CO₂ reforming or for hydrocarbon CO₂ reforming only. The reject from the permeator stream containing non-permeate hydrocarbon and CO can be optionally fed into a consecutive catalytic steam reforming reactor.

14g [Fig.7, shows a similar process as in Fig.6 in which the initial feedstock consists only of CO and steam, to undergo water gas shift reaction only in the first catalytic

permreactor. The reject from the permeator, CO stream, can be recycled into the initial permreactor or optionally fed into a consecutive water gas shift reactor.]

Fig.7, shows a similar process with this in Fig.6, in which the initial feedstock consists only of carbon monoxide (CO) and steam to undergo only the water gas shift reaction in the first catalytic permreactor. The reject from the permeator, CO stream, can be recycled into the first permreactor or optionally fed into a consecutive water gas shift reactor.

14h [Fig.8, shows a permreactor-permeator or reactor-permeator system applied for catalytic dehydrogenation of C₁-C₄ or higher alkane hydrocarbons; the reject from the membrane permeator olefinic stream can be used for polyolefin production.]

Fig.8, shows a process which includes a permreactor-permeator or a non-permeable reactor-permeator applied in the catalytic dehydrogenation of C₁-C₄ or higher alkane hydrocarbons. The permeate stream from the membrane permeator may consist of hydrogen or olefin depending on the type of membrane used for the separation. In the case which hydrogen permeates through the membrane, the reject from the permeator olefin rich stream can be used for polyolefin production in a consecutive reactor. In case of olefin separation through the permeator, the reject paraffin rich stream can be recycled into the first permreactor.

14i [Fig.9, shows a catalytic permreactor-permeator system for the hydrocarbon steam reforming reaction. The reject from the membrane permeator hydrocarbon and CO stream can be recycled into the initial reformer or fed into a consecutive steam reforming reactor.]

Fig.9, shows a catalytic permreactor-permeator process for the hydrocarbon or alcohol steam reforming reaction. The reject from the membrane permeator hydrocarbon and carbon monoxide stream can be recycled into the initial reformer or fed into a consecutive (second) steam reforming reactor.

14j [Fig.10, shows a system of a catalytic permreactor or impermeable reactor with a consecutive cryogenic separator for hydrocarbon steam and CO₂ reforming or for hydrocarbon CO₂ reforming only. The one stream separated from the cryogenic separator, containing hydrocarbon, CO₂ and steam can be alternatively fed into the inlet of the initial reforming reactor.]

Fig.10, shows a process of a catalytic permreactor or non-permeable reactor which combines a consecutive cryogenic separator for hydrocarbon steam and CO₂ reforming or for hydrocarbon CO₂ reforming only. The one liquified stream separated from the cryogenic separator, containing hydrocarbon, CO₂ and steam can be alternatively fed into the inlet of the initial reforming reactor. The gaseous stream from the separator contains H₂ and CO.

14k [Fig.11, shows a system of a catalytic permreactor or impermeable reactor for hydrocarbon steam and CO₂ reforming or hydrocarbon CO₂ reforming only with complete conversion of hydrocarbon and CO₂ gases to H₂ and CO, which product mixture is fed directly into a SOFC (solid oxide fuel cell) unit for electric current generation.]

Fig.11, shows a process which includes a catalytic permreactor or non-permeable reactor for hydrocarbon steam and CO₂ reforming or hydrocarbon CO₂ reforming only with complete conversion of hydrocarbon and CO₂ gases in the

reactor to H₂ and CO, which product mixture is fed directly into a SOFC (solid oxide fuel cell) or a MCFC (molten carbonate fuel cell) unit for electricity generation.

14l [Fig.12, shows a system of a catalytic permreactor or impermeable reactor followed by a membrane permeator for hydrocarbon steam and CO₂ reforming or hydrocarbon CO₂ reforming only with complete conversion of hydrocarbon and CO₂ feedstocks to H₂ and CO which product mixture enters into the permeator which separates H₂ via permeation from CO.]

Fig.12, shows a process which includes a catalytic permreactor for hydrocarbon, steam, and CO₂ reforming or hydrocarbon CO₂ reforming only with a consecutive methanol synthesis reactor from hydrogen, CO and CO₂ or from hydrogen and CO only. Methanol from the second reactor can be used as fuel, synthesis chemical or as feed in methanol powered fuel cells.

14m [Fig.13, shows a system of a catalytic permreactor for hydrocarbon, steam and CO₂ reforming or hydrocarbon CO₂ reforming only with a consecutive methanol synthesis reactor from hydrogen, CO and CO₂ or hydrogen and CO only followed by a methanol steam reforming reactor for production of H₂ and CO₂. The system of reactors includes recycling streams of H₂ and CO₂ for increasing the overall process efficacy.]

Fig. 13, shows a process which comprises of a catalytic permreactor applied in the catalytic dehydrogenation of C₁-C₄ or higher alkane hydrocarbons and takes place within the intermediate catalytic annular space. In the two adjacent tubes a hydrogenation reaction is taking place by using the hydrogen permeated via the

membrane tubes. Instead of dehydrogenation reaction, steam or CO₂ reforming of hydrocarbons or water gas shift can take place to produce the permeate hydrogen.

14n A similar process can be applied in same figure 13 for methane oxidation to synthesis gas, or methane oxidative coupling to C₂ hydrocarbons. The suitable oxidation catalyst is placed in the inner and outer tubes, and in the empty central annular space within oxygen or air is flowing continuously. The process uses solid oxide type membranes which allow oxygen ions to permeate through the membranes, inside the tubes and react with methane to form synthesis gas or C₂ hydrocarbons.

DETAILED DESCRIPTION OF THE DRAWINGS

15 [Fig.1 shows a cross section of the membrane reactor to be used in steam and carbon dioxide reforming of hydrocarbons, steam reforming of alcohols, water gas shift and dehydrogenation reactions, which consists of a concentric double wall cylindrical assembly with tubular type heaters located within the catalyst, along the catalyst zone. An outer impermeable tube (7) nests the two permeable concentric tubes. Reacting feedstocks such as steam and hydrocarbon, CO₂ and hydrocarbon, steam, CO₂ and hydrocarbon, steam and alcohols, or alkanes (paraffins) such as ethane, propane, n-butane, i-butane, pentane, naphtha and higher paraffins, are fed within the main catalyst zone (4) through special inlet fittings and they react in the catalyst to produce hydrogen, carbon monoxide, carbon dioxide. Optionally, small volumetric quantities of hydrogen can be added into above feedstocks to prevent heavy catalyst deactivation in the reactor inlet, wherein propensity for hydrocarbon cracking into carbon is high in absence of any hydrogen. The hydrocarbon reforming catalyst can be nickel, ruthenium, rhodium,

palladium enriched with earth type metals such as potassium, calcium, magnesium, lanthanum, cerium, and supported on alumina, silica, titania, zirconia or other inorganic oxide. For the water gas shift reaction the catalytic metal can be nickel, also iron, copper, zinc, chromium, cobalt enriched with and supported on similar metal oxides. The methanol reforming catalysts can be zinc, chromium, copper, iron, nickel, ruthenium, rhodium, palladium. Finally, the above described reactor design is applied as well for paraffin (alkane) dehydrogenation reactions and the reactor becomes a catalytic dehydrogenator which utilizes platinum, chromium, palladium catalysts enriched with and supported on similar inorganic oxides.]

Fig.1 shows the top cross section of the double wall membrane process reactor (permreactor) used in the process of steam and carbon dioxide reforming of hydrocarbons, steam reforming of alcohols, water gas shift and alkane dehydrogenation reactions. It consists of a concentric double membrane wall cylindrical assembly with tubular type heaters located within the catalyst, along the main catalyst zone. An outer impermeable tube (7) nests the two permeable concentric tubes (1) and (2). Reacting feedstocks such as steam and hydrocarbons, CO₂ and hydrocarbons, steam, CO₂ and hydrocarbons, steam and alcohols, or alkanes such as ethane, propane, n-butane, i-butane, pentane, naphtha and higher paraffins, are fed within the main catalyst zone (4) through special inlet fittings and react in the catalyst to produce hydrogen, carbon monoxide, carbon dioxide. Optionally, small volumetric quantities of hydrogen can be added into above feedstocks to prevent the deactivation of catalyst in the inlet of the reactor, wherein propensity for hydrocarbon cracking into carbon is high in the absence of hydrogen.

The hydrocarbon reforming catalysts can be nickel, ruthenium, rhodium, palladium, platinum, iridium, chromium, cobalt, enriched with earth type metals such as calcium, lanthanum, sodium, potassium, magnesium, manganese, boron, barium, lithium, cerium, cesium, yttrium, and supported on oxides of alumina (Al_2O_3), titania (TiO_2), silica (SiO_2), zirconia (ZrO_2), lanthanum (La_2O_3), types of glass or on other inorganic or metal oxides. For the water gas shift reaction the catalytic metals can be nickel, iron, copper, zinc, chromium, cobalt, molybdenum, enriched with similar earth metals and supported on similar metal oxides. The methanol reforming catalysts can be zinc, chromium, copper, iron, nickel, ruthenium, rhodium, palladium, molybdenum, enriched with and supported on similar metal and metal oxides. Finally, the described permreactor process is applied as well for alkane dehydrogenation reactions and it becomes a catalytic dehydrogenation process which utilizes platinum, chromium, palladium, rhodium, ruthenium, zinc, silver, nickel, copper, catalysts enriched with and supported on similar metal and inorganic oxides. The above catalysts are also used in the next embodiments (figures) of the described reaction-catalysis processes.

16 [Hydrogen is removed along the inner membrane tube (2), wherein the membrane is made by a metal or inorganic (non-porous or porous), porous inorganic-metal or carbon material. Carbon monoxide, carbon dioxide, steam, hydrocarbons, alcohols may also permeate through first membrane in a lesser degree than hydrogen if the membrane is porous inorganic or inorganic-metal. An inert carrier gas such as argon, nitrogen, steam or a mixture of these gases may flow along the permeate annulus, between tubes (2) and (1), through suitable inlet fittings, to carry the permeate components at a specific

pressure value. Permeate hydrogen is further removed through permeation along the outer membrane tube (1) so that permeated stream contains pure hydrogen only, with pure hydrogen to be used in various applications including feed to synthesis reactors, gas turbines and engines, and fuel cells. Outer membrane tube (1) is made by a metal, non-porous inorganic or carbon membrane which allows only hydrogen to permeate through, and therefore purifies hydrogen from the permeating carbon oxides, steam and hydrocarbons, in the annular zone between the two membrane tubes.]

The reactant pressurized gas is fed into the main catalytic zone (4) and the pressure in this zone is maintained the highest. The pressure drops progressively from zone (4) to zone (8) to zone (5), with outer zone (5) to be at the lowest pressure. This pressure gradient is necessary to maintain an outward permeation and flow of the selective gases radially from membrane (2) to membrane (1). Hydrogen is removed first along the inner membrane tube (2), wherein the membrane material can be a dense metal, a porous or non-porous inorganic, a porous or non-porous inorganic-metal, or another porous or non-porous composite material. Carbon monoxide, carbon dioxide, steam, hydrocarbons, alcohols may also permeate through first membrane (2) in a lesser degree than hydrogen if the membrane is made by a porous material. An inert carrier gas such as argon, nitrogen, steam or a mixture of these gases may also flow along the permeate annulus, between tubes (2) and (1), through suitable inlet fittings, to carry the permeate components at a fixed pressure. Permeate hydrogen is further removed via permeation along the outer membrane tube (1), so that permeated stream contains pure hydrogen only, with pure hydrogen to be used in various applications including feed to synthesis reactors, gas turbines

and engines, and fuel cells. Outer membrane tube (1) can be made by a dense metal, non-porous inorganic, or composite membrane which allows only hydrogen to permeate through, and therefore purifies hydrogen from the permeating carbon oxides, steam and hydrocarbons, flowing in the annular zone between the two membrane tubes.

17 Metal materials permeable to hydrogen for the membrane tubes (1) and (2), include palladium, vanadium, [and] palladium alloys such as palladium-nickel, palladium-silver, palladium-zinc, palladium-chromium, palladium-copper, palladium-tungsten and others. Hydrogen permeable non-porous inorganic membranes include silicon carbide, silicon nitride, tungsten carbide, tungsten nitride, titanium carbide, titanium nitride, tantalum carbide, tantalum nitride and others. Porous inorganic membranes include oxides of alumina, silica, titania, zirconia, various types of glass and others. [Carbon] Composite type membranes are made by deposition or [other] fabrication [method (i.e., pyrolysis) of carbon or carbonaceous materials within] of a metal into a porous inorganic substrate (support) to make it hydrogen permeable. Metal and metal alloys can be deposited on porous inorganic or metal surfaces to make them hydrogen permeable. Palladium and other metal [deposition] deposited [as] membranes can be [done with] fabricated by electroless plating, electroplating, sputtering, chemical vapor deposition, physical vapor deposition and other applicable metal deposition or metallization techniques. Inorganic [,] or inorganic-metal membrane materials can be deposited as well in porous inorganic or metal surfaces (e.g., tubes) via various deposition techniques including incipient wetness, dip coating and sol gel methods.

18 Organic polymer, composite or copolymer membranes can be made by polymers such as polyimides, polycarbonates, polysulfones, polybenzimidazoles, polyphosphazenes, polyamides, polystyrenes, polycaprolactams, parylenes, polyvinyl halides, polyacetates, polysiloxanes and others in order to be permeable to hydrogen or to hydrogen and carbon dioxide. Finally, composites of the previous materials can be also made as hydrogen permeable membranes such as inorganic-metal, inorganic-organic, inorganic-metal-organic composites. Metal, [and] metal alloy, non-porous inorganic, and types of composite [carbon] membranes are highly selective to hydrogen, while porous inorganic, organic, and some types of porous composite membranes are also [usually] selective to other species as well. The disclosed double [permeable] wall [reactor design] permreactor process can [be fabricated by selecting] utilize among the aforementioned materials to satisfy the necessary process requirements [for the reactor itself and the consecutive application processes disclosed later in the text]. The described membranes (1), (2) can also act as catalysts to catalyze the occurring reactions.

19 The external space, created between the outer [hydrogen permeable] membrane tube (1) and the impermeable far outer shell (7), which receives the final permeate hydrogen, can be either empty, or may contain a selective catalyst (5) which converts the permeate hydrogen after its combination with [a] another component flowing [in] via [the] this external space [parallel to the outer membrane tube]. Such a flowing (sweep) component can be an unsaturated hydrocarbon (e.g., alkenes, alkynes) for conversion to saturated hydrocarbons after [reaction] combination with hydrogen, in an exothermic reaction. Flowing (sweep) component can be also carbon monoxide for direct production of methanol or [gasoline] hydrocarbons (through Fischer-Tropsch synthesis) after

combination with [the] permeate hydrogen in also exothermic type reactions. Flowing gas can be nitrogen for exothermic ammonia synthesis after its combination with the permeate hydrogen. Other combination reactions of flowing [species] compounds with permeate hydrogen can be these for reduction of aromatic hydrocarbons, also these for saturation of unsaturated alcohols, phenols, aldehydes, ketones, acids, these for reduction of alkyl and aryl halides and these for reduction of nitroalkanes and aromatic nitro compounds to corresponding primary amines. The heat generated by exothermic reactions in the external shell [,] may be transferred into the inner catalytic reaction zone (1) [of the inner membrane tube] via the radial direction, thus providing for part of the heat load necessary to drive the endothermic catalytic reactions -in the inner membrane tube] therein.

20 Permeation of reaction products through the membrane tubes, especially **this** of hydrogen through the inner membrane tube (2), shifts the thermodynamic equilibrium conversion of reactant species to the product side and produces excess hydrogen and carbon oxides [products] within the catalytic reaction zone (4). Outer membrane tube (1) thereby, serves as a final permeable medium for the recovery of highly pure hydrogen product for use in hydrogen utilization applications. Outer metal membrane tube (1) serves also as a separation medium for hydrogen out of the central annular zone between the two membrane tubes, so that **the** partial pressure of hydrogen lowers substantially along the annular zone, and [therefore] **therby** continuous driving force exists for [hydrogen] permeation of hydrogen from the catalytic reaction zone (4) [to] into the central annular zone (8).

21 As an alternative to the invented process and design, for low operating gas reforming and dehydrogenation temperatures (e.g., between 200-(400)500°C) and in the absence of steam as [a] reactant, the inner membrane tube (2) can be made by porous inorganic or porous inorganic-metal materials and the outer membrane tube (1) can be made by dense high temperature organic materials [which withstand high temperature] (i.e., materials [with] having high glass transition temperature, Tg) [, and] which are permselective to both hydrogen and carbon dioxide. The last two gases [which] permeate through the inner tube (2) and flow along the central annular zone (8).

[The mixture of H₂ and CO₂ can be used directly in chemical synthesis applications such as this of alternative methanol synthesis via the reaction: CO₂+3H₂=CH₃OH+H₂O, and as direct feed in molten carbonate fuel cells via the overall electrochemical reaction: H₂+CO₂+1/2O₂ → H₂O+CO₂].

The recovered mixture of H₂ and CO₂ can be used directly in chemical synthesis applications such as this of alternative methanol synthesis (CO₂+3H₂=CH₃OH+H₂O, reaction (6)) or formic acid synthesis (CO₂ + H₂ = HCOOH, reaction (8)) and as direct feed in molten carbonate fuel cells via the overall electrochemical reaction:



Moreover mixtures of H₂ and CO₂ can be converted to CH₄ or CO, if a special application requires, via the methanation or reverse water gas shift reactions respectively [given] as shown below:



22 The external (outer) membrane (1) serves also as a backup membrane medium in case the inner membrane (2) develops cracks or defects and its permeability to various gases increases. In this case, the outer membrane (1) will selectively separate specific gases based on the selected membrane material as described above. [Moreover, operational and maintenance service for replacing old or damaged membrane and outer non-membrane tubes becomes easier with the proposed design, because each part of the reactor is interconnected with the rest and can be disassembled and assembled accordingly.] Moreover, operational and maintenance service for replacing old or damaged membrane tubes and catalysts become easier with the proposed design, because the parts of the permreactor are interconnected properly via top and bottom caps and can be disassembled and assembled accordingly. The top and bottom ends where the tubes are interconnected are sealed with proper materials or welded or glazed to prevent gas flow or leak between the various compartments.

23 An optional design of the permreactor may include an additional catalytic zone (8) which is created between the inner membrane tube (2) and the outer membrane tube (1) and can be used in various reactions and processes. Heating of the reformer or reactor is achieved via cylindrical tubes (6) arranged symmetrically around the axial reactor axis and operated in the gas combustion regime by flowing waste type hydrocarbons or hydrocarbon-hydrogen mixtures mixed with oxygen or air. Unreacted hydrocarbons, carbon monoxide, non-permeate hydrogen or any mixture of these species from the catalytic reformer outlets (4), (5), (8), can be recycled as well into the heating [combustion] tubes (6). Flue or waste gases coming out from the interconnected fuel cells, engines or turbines can be also used directly to provide the

necessary heat load into tubes (6). In an alternative heating configuration, a single cylindrical tube having the shape of a tube or a coil is located along the reactor axis in zone (4) and can be operated by using same quality of combusted gases. In a third alternative configuration the symmetrically located tubes in (4) [with flowing gas] can be replaced by cylindrical electric heaters, heating bars or coils.

24 [Fig.2, shows multiple double permeable wall reactors of those described in Fig.1, but without the far outer impermeable tube (7), which are placed symmetrically inside a larger impermeable tube (A1), to create a multiple tube reformer with a common external area for collecting final permeate hydrogen.]

Fig.2, shows a lateral sectional view of the process permreactor described in Fig.1. The embodiment includes catalyst beds 4, 5 and 8 placed along the different tubular sections of the permreactor. The most inner tube bears inner membrane 2 while next inner tube bears outer membrane 1. The most inner tube includes tubular heating elements A6 along its axial length. Feedstock gases are entered into the permreactor via inlet ports A1 and the product and reactant gases exit via outlet ports A3. Alternative safety outlets A5 are located in the outer shell to discharge excess pressure in case of a sudden increase. Top and bottom caps A2 and A4 close the inlet and outlet of the tubular permreactor system and seal properly the ends of the different tubes by means of proper fittings or by using seal or glaze type materials or welding to prevent unwanted gas flow or leak between the tubes.

25 [Fig.3 shows another developed reformer or reactor design to be used in steam and carbon dioxide reforming of hydrocarbons, steam reforming of alcohols, water gas shift and dehydrogenation reactions. Reformer or reactor consists of a most outer impermeable tubular cylinder (shell) (1) which is hollow inside in order to nest two more concentric tubular cylinders, a next inner one (2) and finally a most-inner (3) which both are made by permeable materials. Most outer cylinder (1) is made by impermeable stainless steel or alloys, but next-inner cylinder (2) consists of metal, metal alloys, non-porous and porous inorganics, porous inorganic-metals or carbon materials such as those described in embodiment of Fig.1.

The derived concentric cylindrical assembly has proper inlet and outlet fittings for feeding the feedstocks and discharging the post-reaction species. Proper inlet and outlet fittings are interconnected with the different sites of the cylindrical assembly. Fittings are connected to the annular space between most-outer and next-inner cylinders to deliver and collect gases flowing in this space. Additional independent fittings are connected to the annular space between the next-inner and most-inner cylinders to deliver and collect gases flowing in this space. Additional independent fittings are connected to the tubular space of the most-inner cylinder to deliver and collect gases flowing in this space. The fittings are made in such a manner so that they can seal in a leak-free manner each corresponding space, and the overall cross section of the double permeable wall cylindrical tube assembly. Before the fittings are applied and tighten, the annular space between the most outer (external) and next-inner cylinders is filled with the proper reaction catalyst in pellet or particle form to make the catalytic reaction zone (4). Proper catalyst is used for each reforming, water gas shift and dehydrogenation reactions.

Catalysts used in these reactions are same with those mentioned above in description of embodiment of Fig. 1.

In steam, CO₂ reforming of hydrocarbons, steam reforming of alcohols, water gas shift and paraffin dehydrogenation reactions, hydrogen is removed along the next-inner lateral cylindrical metal membrane surface (2), with carbon monoxide, carbon dioxide, steam, hydrocarbons, alcohols to possibly also permeate through inner lateral membrane surface in a lesser degree than hydrogen depending on the membrane material used. An inert carrier gas such as argon, nitrogen, steam or a mixture of those gases, may flows along the permeate annulus, between tubes (2) and (3), through suitable inlet fittings, to carry the permeate components at a specific pressure value. Permeate hydrogen is further removed through permeation along the lateral surface of most-inner membrane tube (3) so that the final permeated stream contains pure hydrogen only, with pure hydrogen to be used in various applications including feed to synthesis reactors, gas turbines and engines, and fuel cells.

The most-inner membrane tube (3) is made by a metal, metal alloy, non-porous inorganic or carbon membrane which allows only hydrogen to permeate through and therefore purifies hydrogen from the permeating carbon oxides, steam and hydrocarbons, flowing in the annular zone created between the next-inner and most-inner cylindrical tubes. Membrane tubes (2) and (3) can be made with similar manufacturing techniques as those described in embodiment of Fig. 1. The most-inner membrane tube can be either empty or may contain a selective catalyst (5) which converts permeate hydrogen combined with another component flowing through the inner bore of this tube. Such a flowing (sweep) component can be an unsaturated hydrocarbon (e.g., alkenes, alkynes)

for conversion to saturated hydrocarbons, after reaction with the permeate hydrogen in an exothermic reaction. Flowing (sweep) component for hydrogenation by the permeate hydrogen can be also carbon monoxide for direct production of methanol or gasoline hydrocarbons (through Fischer-Tropsch synthesis) in exothermic type reactions. Flowing (sweep) gas can be nitrogen for exothermic ammonia synthesis after combination with the permeate hydrogen. Other combination reactions with permeate hydrogen can be these for reduction of aromatic hydrocarbons, also these for saturation of unsaturated alcohols, phenols, aldehydes, ketones, acids, these for reduction of alkyl and aryl halides and these for reduction of nitroalkanes and aromatic nitro compounds to corresponding primary amines. Alternatively, pure permeate hydrogen can be used as direct feed in hydrogen based turbines and engines, fuel cells, and other power generation equipment. The heat generated by exothermic reactions in the most-inner cylindrical bore, may be transferred into the catalytic reaction zone of the outer membrane cylinder via the radial direction, thus providing part of the heat load necessary to drive the endothermic catalytic reactions in catalyst bed (4) located within the outer membrane cylinder.

Permeation of hydrogen through the first inner membrane tube, shifts the thermodynamic equilibrium conversion of reactant species to the product side and produces excess hydrogen and carbon oxide products for reforming and water gas shift reactions, and hydrogen only for paraffin dehydrogenation reactions.

Most-inner membrane tube thereby, serves as a final permeable medium for the recovery of highly pure hydrogen product for use in hydrogen utilization applications. Most-inner metal membrane tube serves also as a separation medium for hydrogen out of the annular zone between the two hollow cylindrical membrane tubes, so that partial

pressure of hydrogen lowers substantially along the annular zone, and therefore continuous driving force exists for hydrogen permeation from the enclosed catalytic reaction zone (4) to the central annular zone (7), through the next inner membrane tube (2).

As an alternative to the invented design, for low operating gas reforming and dehydrogenation reaction temperatures (e.g., between 200-400°C) and in the absence of steam as a reactant, the next-inner membrane tube (2) can be made by porous inorganic or inorganic-metal materials which are permeable to several species diffusing out of the reaction zone (4), and the most-inner membrane tube (3) can be made by organic materials which withstand high temperatures (have high glass transition temperature, T_g) and are permselective to both hydrogen and carbon dioxide species which flow along the central annular zone (7). The binary permeate mixture of H₂ and CO₂ can be used in applications described already in embodiment of Fig.1.

The most-inner membrane serves also as a backup membrane medium in case the first-inner membrane develops cracks or defects and its permeability to various gases increases. In this case, the most-inner membrane will selectively separate specific gases based on the selected membrane material as described above. Moreover, operational and maintenance service for replacing old or damaged membrane and outer non-membrane tubes becomes easier with the proposed design, because each part of the reactor is interconnected with the rest and can be disassembled and assembled accordingly.

Heating of the described reformer or reactor is achieved via external heat provision (6). The external to the reformer combustion regime can be fueled by flowing waste type hydrocarbons or hydrocarbon-hydrogen mixtures mixed with oxygen or air.

Unreacted hydrocarbons, carbon monoxide product, non-permeate hydrogen product, or any mixture of these post-reaction species coming out of the cylindrical reformer outlet connected with the catalyst zone (4), can be recycled as well into the external combustion-heating zone (6). Optionally, external heating of most-outer shell (1) can be provided by cylindrical type heaters or heating elements (i.e., made by ceramic, composite materials) in contact with the shell.]

Fig.3, shows multiple double wall process permreactors of those described in Fig.1, but without the far outer impermeable tube (7), which all are placed symmetrically inside a larger impermeable tube (A1), to create a multiple tube reactor with a common external area for collecting final permeate hydrogen. The common external area may contain a catalyst (zone 5) wherein a catalytic reaction is conducted as described in Fig.1 above. This type of process configuration is able to process large amounts of reacting feedstocks and to produce larger throughputs of product mixtures in comparison with the single module process of Fig.1.

26 [Fig.4, shows multiple double permeable wall cylinder reactors of those described in Fig.3, which are placed symmetrically inside a larger impermeable tube (shell) (A1), to create a multiple tube reformer with a common external heating area.]

Fig.4 shows the top cross sectional view of another developed double wall membrane process reactor (permreactor) used in the process of steam and carbon dioxide reforming of hydrocarbons, steam reforming of alcohols, water gas shift and alkane dehydrogenation reactions. Overall reactor process consists of a most outer hollow impermeable tube (outer shell) (1) which nests two more concentric hollow

permeable tubes, a next inner one (2) and a most-inner (3). Most outer cylinder (1) is made by impermeable metal or alloy such as stainless steel. Next-inner membrane tube (2) is made by a dense metal or a metal alloy, a non-porous or porous inorganic, a non-porous or porous inorganic-metal, or another non-porous or porous composite material which is permeable and selective to hydrogen.

27 The derived concentric multitube assembly has proper inlet and outlet fittings for feeding the feedstocks and discharging the post-reaction species similar to those described in Fig.1 and Fig.2 above. Inlet and outlet fittings are connected into the ends of the three different tubular cylinders similarly to those shown in Fig.2, to deliver and collect gases flowing through these spaces. Top and bottom caps are also used to seal the ends of the overall reactor. Before the caps are applied and tighten, the annular space between the different cylinders is filled with the appropriate catalyst in pellet or particle form to make the catalytic reaction zones (4), (5) and (7). Proper catalyst is used for each reforming, water gas shift and dehydrogenation reactions. Catalysts used in these reactions are same with those mentioned above in the description of embodiment of Fig.1. The pressure is higher in zone (4) and drops progressively inwards from zone (4) to zone (7) to zone (5), with zone (5) to be at the lowest pressure. This pressure gradient assures the selective permeation and flow of gases inwards from membrane (2) to membrane (3).

28 In steam, CO₂ reforming of hydrocarbons, steam reforming of alcohols, water gas shift and alkane dehydrogenation reactions, hydrogen is removed along the next-inner lateral membrane surface (2), with carbon monoxide, carbon dioxide, steam, hydrocarbons, alcohols to possibly also permeate through the same membrane

surface in a lesser degree than hydrogen depending on the type of the membrane material used. An inert carrier gas such as argon, nitrogen, steam or a mixture of those gases, may flows along the permeate annular zone, between tubes (2) and (3), through the inlet fittings, to carry the permeate components at a specific pressure value. Permeate hydrogen is further removed through permeation along the lateral surface of most-inner membrane tube (3) so that final permeate stream contains pure hydrogen only, with pure hydrogen to be used in various subsequent applications including feed to synthesis reactors, gas turbines and engines, and fuel cells.

29 The most-inner membrane tube (3) is made by a dense metal or metal alloy, non-porous inorganic or composite membrane which allows only hydrogen to permeate through and therefore purifies the hydrogen from the permeating carbon oxides, steam, hydrocarbon and alcohol compounds, flowing in the central annular zone (7). The membranes in tubes (2) and (3) can be made with similar manufacturing techniques as those described in embodiment of Fig.1. Membranes (2) and (3) can act also as catalysts to catalyze the occurring reactions. The most-inner membrane tube can be either empty or may contain a selective catalyst (5) which can convert permeate hydrogen after combination with another component flowing through the inner bore of this tube. Such a flowing (sweep) component can be an unsaturated hydrocarbon (e.g., alkenes, alkynes) for conversion to saturated hydrocarbons after exothermic reaction with the permeate hydrogen. Flowing (sweep) gas for hydrogenation can be also carbon monoxide for direct production of methanol or gasoline hydrocarbons (through Fischer-Tropsch synthesis) in also

exothermic type reactions. Flowing (sweep) gas can be nitrogen for exothermic ammonia synthesis after combination with the permeate hydrogen. Other combination reactions with permeate hydrogen can be these for reduction of aromatic hydrocarbons, these for saturation of unsaturated alcohols, phenols, aldehydes, ketones, acids, these for reduction of alkyl and aryl halides and these for reduction of nitroalkanes and aromatic nitro compounds to corresponding primary amines. Alternatively, pure permeate hydrogen can be used as direct feed in hydrogen based turbines and engines, fuel cells, and other power generation equipment. The heat generated by exothermic reactions in the most-inner cylindrical bore (5), may be transferred radially into the catalytic reaction zone of the outer membrane cylinder, thus providing for part of the heat load necessary to drive the endothermic reactions in catalyst bed (4) located between tubes (2) and (1).

30 Permeation of hydrogen through first inner membrane tube (2), shifts the thermodynamic equilibrium conversion of reactant species to the product side and produces excess hydrogen and carbon oxide products in zone (4). Most-inner membrane tube (3) thereby, serves as a final permeable medium for the recovery of highly pure hydrogen for use in hydrogen utilization applications. Most-inner membrane tube (3) serves also as a separation medium for hydrogen out of the central annular zone (7) so that partial pressure of hydrogen lowers substantially along the annular zone, and thereby continuous driving force exists for permeation of hydrogen from the catalytic reaction zone (4) into the central annular zone (7).

31 As an alternative to the disclosed process and design, for low operating gas reforming and dehydrogenation temperatures (e.g., between 200-500°C) and in the

absence of steam as reactant, the inner membrane tube (2) can be made by porous inorganic or porous inorganic-metal materials and the most inner membrane tube (3) can be made by dense high temperature polymeric materials (i.e., materials having high glass transition temperature, Tg) which are permselective to both hydrogen and carbon dioxide. The last two gases may first permeate through the inner membrane (2) and flow along the central annular zone (7) as they permeate through membrane tube (3). The recovered mixture of H₂ and CO₂ in zone (4) can be used in the applications already described in embodiment of Fig.1.

32 The most inner membrane tube (3) serves also as a backup membrane in case first inner membrane (2) develops cracks or defects and its permeability to various gases increases. In this case, the most inner membrane (3) will selectively separate specific gases including hydrogen, based on the selected membrane materials as described above. Operational and maintenance service for replacing old or damaged membrane tubes and catalysts in the described permreactor become easier with the proposed design, because the parts of the permreactor are interconnected properly via top and bottom caps and can be disassembled and assembled accordingly. The top and bottom ends of the interconnected tubes are sealed, glazed, or welded with proper materials to prevent gas flow and leaks between the various compartments.

33 An optional design of the permreactor may include an additional catalytic zone (7) which is created between the inner membrane tube (2) and the most inner membrane tube (3) and can be used in various reactions and processes.

34 Heating of the described reactor is achieved via external heat provision (zone 6). The external to the reformer combustion regime can be fueled by flowing waste

type hydrocarbons or hydrocarbon-hydrogen mixtures mixed with oxygen or air. Flue or waste gases coming out from the interconnected fuel cells, engines or turbines can be also used directly to provide the necessary heat in zone (6). Unreacted hydrocarbons, carbon monoxide product, non-permeate hydrogen product, or any mixture of these post-reaction species coming out of the outlets connected with the catalyst zones (4), (5) or (7) can be recycled as well into the external combustion-heating zone (6). Optionally, external heating of most-outer tube (1) can be provided by cylindrical type heaters or heating elements in contact with the outer tube. Thus, the lateral sectional view of the processing permreactor described in Fig.4 is similar with this of Fig.2 with the exception that there are no tubular type heaters in the most inner annular zone (5) as in case of Fig.1 and Fig.2.

35 [Fig.5 shows a cross section of a reformer or dehydrogenation reactor which consists of multiple cylindrical hollow polymer membrane tubes or fibers (1) nested within an outer impermeable metal cylindrical tube (2) which also contains the catalyst (3) in particle or pellet form, for the specific reactions mentioned below.

Reacting gas feedstocks free of steam such as CO₂ and hydrocarbons also paraffin hydrocarbons are fed within the catalyst zone (3) through special inlet fittings and they react in the catalyst to produce hydrogen and carbon monoxide or hydrogen and olefins. Optionally, small volumetric quantities of hydrogen can be added into above feedstocks in inlet of the reactor assembly, to prevent heavy catalyst deactivation in the reactor inlet, wherein propensity for hydrocarbon cracking into carbon is high in absence of any hydrogen. The CO₂ (dry) reforming or dehydrogenation catalysts are the same metallic

type with those described in embodiment of Fig.1. Steam is avoided as a reactant in the reactor to avoid long term plasticization and structural damage of membrane tubes and loss of related permeability and selectivity properties.

Hydrogen product from these reactions is removed along the surface of the multiple membrane tubes (1), wherein the membranes are made by organic polymer or composite polymer membranes. Traces of carbon monoxide, carbon dioxide, product steam, olefins, and unreacted hydrocarbons may also permeate through the membrane tubes (1) in a lesser degree than hydrogen. The permeate gas mixture is continuously removed through the inner side of the membrane tubes and flows into a common impermeable metal shell which is interconnected with all the membrane tubes and sealed from the gases flowing into the catalytic reaction side (3). Optionally, a flowing component can flow along the inner membrane tube to sweep and dilute the permeate gas as it flows through the tubes.

In an optional design, catalyst in form of pellets or particles (4) can be contained within the inner side of the polymer membrane tubes to carry suitable catalytic reactions (such as hydrogenations) in which one of the reacting species is permeate hydrogen and the other reaction species are contained within the flowing gas. Such a flowing (sweep) component can be an unsaturated hydrocarbon (e.g., alkenes, alkynes) for conversion to saturated hydrocarbons, after reaction with hydrogen, in an exothermic reaction. Flowing (sweep) component can also be carbon monoxide for direct production of methanol or gasoline (through Fischer-Tropsch synthesis) after combination with the permeate hydrogen, in exothermic type reactions. Flowing gas can be nitrogen for exothermic ammonia synthesis after its combination with the permeate hydrogen. Other combination

reactions with permeate hydrogen over specific metallic catalysts, can be these for reduction of aromatic hydrocarbons, also these for saturation of unsaturated alcohols, phenols, aldehydes, ketones, acids, these for reduction of alkyl and aryl halides and these for reduction of nitroalkanes and aromatic nitro compounds to corresponding primary amines. Part of the heat generated by the exothermic reactions in the inner side of the tubes, may be transferred across the membranes, into the common catalytic reaction zone (3) surrounding the multiple membrane tubes, thus providing part of the heat load necessary to drive the endothermic catalytic reactions in catalyst zone (3).

Permeation of reaction products and especially hydrogen through the membrane tubes (1), shifts the thermodynamic equilibrium conversion of reactant species to the product side and produces excess hydrogen, carbon oxide, and olefins respectively within the catalytic reaction zone (3). Permeate collected hydrogen through the inner tubes (1), can be used in chemical synthesis or fuel applications as described in embodiment of Fig.1.

As an alternative to the disclosed design, for low operating reforming and dehydrogenation temperatures (e.g., between 200-400°C), the inner tubes (1) can be made by materials which are permselective to both hydrogen and carbon dioxide products which permeate along the surface of the tubes (1). The separated mixture of H₂ and CO₂ can be used in applications described in embodiment of Fig.1.

The main heating of the catalyst zone (3), is achieved via external heating (5) of the impermeable most-outer reactor shell (2) through combustion of flowing waste type hydrocarbons or hydrocarbon-hydrogen mixtures mixed with oxygen or air. Unreacted hydrocarbons, carbon monoxide, non-permeate hydrogen or any mixture of these species

coming out of the outlet of catalytic zone (3) can be recycled as well into the external combustion zone (5). Optionally, external heating of outer shell (2) can be provided by any type of cylindrical type heaters or heating elements (i.e., ceramic, composite).]

Fig.5, shows multiple double wall process permreactors of those described in Fig.4, which all are placed symmetrically, inside a larger impermeable tube (shell) (A1), to create a multiple tube permreactor with a common external heating area (6). The most outer impermeable tubes (1) which consist the external part of the multiple tubes are in direct contact with the common heating zone (6). This type of process configuration is able to process large amounts of reacting feedstocks and to produce larger throughputs of product mixtures in comparison with the single module process of Fig.4.

36 [Fig.6, depicts a system of catalytic permreactor with consecutive permeator (or optionally a permreactor) and optionally another final consecutive reactor, for conducting reforming and gas shift reactions. In Fig.6, stream 1 contains hydrocarbon feedstocks such as methane (CH_4), higher alkanes (paraffins), naphtha, and natural gas, mixed with steam and CO_2 and introduced in catalytic permreactor A for conducting simultaneously reactions (1), (2) and (3), or mixed with CO_2 only for conducting reactions (2) and (3). Some hydrogen may be added into stream 1, which is usually between 1-15% of the feed volume, to depress carbon formation from hydrocarbon cracking especially in the inlet of permreactor A.

Catalytic permeable reformer A, is of any of the types described in embodiments of Figs. 1,2,3,4, and 5 above, with H_2 to be separated in permeate stream 1b via valve A1,

in the general case. H₂ and CO₂ combined, can be separated in permeate stream in special applications, if an organic membrane is used in permreactor A. The rejected exit stream from the permreactor may contain product CO together with unreacted steam (H₂O(g)), CO₂, and hydrocarbon, and non-permeate H₂. This stream becomes stream 2 and enters into heat exchanger B, where the unreacted steam is removed through condensation, and by the heat exchanging process new steam is generated in stream 6 from the water or steam of stream 5. Stream 6, can provide steam in permreactor A and reactor E through streams 9 and 10,18 respectively, in an alternative or simultaneous manner via use of valves B1,E1. The steam in 6 acquires the exchanged heat load from stream 2, the hot gas effluent of permeable reformer A, and thus its derived streams 9,10,18 can be mixed directly with streams 1 and 12 which are fed directly into reactors A and E respectively.

Steam from 6 is used via streams 10,18 and valves B1,E1 to provide the initial steam content in reformer E. Stream 7, passes through a bed of particles C (moisture adsorbent) to remove any non-condensed traces of moisture and through exit stream 8 enters into membrane permeator D. Stream 8, contains CO product, non-permeate H₂ product, unreacted hydrocarbon (e.g., CH₄) and CO₂ gases and has been cooled at the operating temperature of permeator D. H₂ or both H₂ and CO₂ are removed in permeate stream 11 of permeator D, through the permselective action of a metal, non-porous inorganic, carbon, or organic membrane respectively. Non permeating stream containing hydrocarbon (e.g., CH₄), CO and CO₂ or hydrocarbon and CO respectively, depending on the type of membrane used in permeator D, exits from permeator D, through stream 12 as reject stream. Stream 12 enters into reformer E, for conducting simultaneously reforming

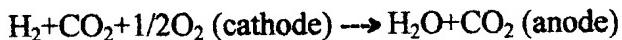
and water shift reactions selected from the group of reactions (1), (2) and (3), and be converted to final H₂, CO, CO₂ or H₂ and CO₂ only products, depending on the feed composition of stream 12 in reformer E. Steam in reformer E is provided via stream 18. Unreacted steam is removed from exit stream 15 by passing this stream through heat exchanger F. Steam is generated from water or steam of stream 16 and via streams 17,18 and valve E1, the generated steam is fed into inlet of reformer E. Exit stream 19 contains H₂, CO, CO₂ or H₂, CO₂ products and traces of unreacted hydrocarbons, depending on the operating conditions, that is the temperature, pressure, space velocity and feed composition of streams 12 and 18, of reformer E. Reformer E, can be replaced by a permeable reformer E similar to permeable reformer A, wherein H₂ is separated in permeate and the reject exit stream 19 consists of CO and CO₂ or CO₂ only.

Reformers A and E are endothermic and flue gas streams 3,4 and 13,14 respectively are used to provide the necessary heat content to drive parallel reactions (1), (2) and (3) to completion. The two reformers can operate at same or different temperature and pressure conditions.

If conversion is high in permeable reformer A under certain operating conditions, the product in stream 2 is mainly CO and H₂ which can be used directly as synthesis gas in methanol synthesis via the direct exothermic reaction: CO+2H₂=CH₃OH, also in Fischer-Tropsch type reactions for production of gasoline type hydrocarbons, and as fuel in gas turbines and engines and solid oxide fuel cells for power generation.

If the overall process consists of two reformers and the intermediate permeator, and the final product is a H₂ and CO₂ mixture in exit stream 19, it can be used separately or it can be mixed with stream 11 to make a combined H₂ and CO₂ stream. This

combined H₂, CO₂ mixture can be used for direct methanol synthesis via the exothermic reaction: 3H₂+CO₂=CH₃OH(g)+H₂O(g). Also, the H₂, CO₂ mixture can be used as direct feed in molten carbonate fuel cells for electricity generation via the overall electrochemical reaction:



Alternatively, CO₂ can be condensed cryogenically from the binary mixture and pure hydrogen can be produced. Final H₂ product can be used for chemical synthesis or as direct feed in fuel cells and gas turbines and engines for power generation applications (e.g., transportation, stationary). Applicable hydrogen driven fuel cells for utilizing the pure separated hydrogen from the process, include proton exchange membrane (PEM), solid oxide (SOFC), molten carbonate (MCFC), alkaline (AFC), phosphoric acid (PAFC) and modifications and combinations of these fuel cells.

Generated hydrogen product from the process can be combined with an unsaturated hydrocarbon (e.g., alkenes, alkynes) for conversion to saturated hydrocarbons in an exothermic type reaction. Also, with carbon monoxide for direct production of methanol (as described above) or gasoline (through Fischer-Tropsch synthesis) in exothermic type reactions. Hydrogen can be also combined with nitrogen for exothermic ammonia synthesis. Other combination (synthesis) reactions with permeate hydrogen can be these for reduction of aromatic hydrocarbons, also these for saturation of unsaturated alcohols, phenols, aldehydes, ketones, acids, these for reduction of alkyl and aryl halides and these for reduction of nitroalkanes and aromatic nitro compounds to corresponding primary amines.

The described process is able to overcome the thermodynamic equilibrium limitations of hydrocarbon (CH_4) and CO_2 reactant conversion, through the removal of H_2 only, or of H_2 and CO_2 gases in membrane permreactor A and permeator D. The calorific value of the obtained H_2 , CO product in permreactor A, is higher than this of the reactant hydrocarbon (e.g., CH_4), CO_2 and steam and the endothermic heat of reaction is stored in the products which can be subsequently used as fuels or in chemical synthesis.

Assuming 100% conversion of reactions (1) and (3) and reaction (2) in equilibrium in permreactor A, 2 mol of CH_4 (with heat of combustion: 425.6 kcal), 1 mol of CO_2 (with no heat of combustion), and 1 mol of $\text{H}_2\text{O(g)}$ (with no heat of combustion), produce 3 mol of CO (with heat of combustion: 202.8 kcal) and 5 mol of H_2 (with heat of combustion: 341.5 kcal). These values are at 25°C. This corresponds to about 28% increase in calorific value for the product. Endothermic heat can be provided in reformers A and E through the combustion of flue or waste gases or unreacted recycled hydrocarbons coming out of the exit of reaction zone of reformers A and E as also described in Figs.1 and 3 above.

In an alternative design, permeator D is replaced by a catalytic permreactor D wherein the water gas shift reaction occurs if stream 8 is rich in product CO . In such case permreactor D is made by metal, non-porous inorganic, or carbon membranes to separate only hydrogen in permeate. Exit reject stream 12 from permreactor D contains product CO_2 and unreacted steam and can be recycled in the first reforming permreactor or used in downstream applications either as a mixture or as pure CO_2 after condensation of the steam.]

Fig.6, depicts a process of catalytic permreactor with a consecutive permeator (or optionally with a second consecutive permreactor) and with an optional third consecutive reactor, for conducting reforming and gas shift reactions. In Fig.6, stream 1 contains hydrocarbon feedstocks such as methane (CH_4), higher alkanes (paraffins), naphtha, natural gas, mixed with steam and CO_2 and introduced in catalytic permreactor A for conducting simultaneously reactions (1), (2) and (3), or mixed with CO_2 only for conducting reactions (1) and (2). Some hydrogen may be added into stream 1, which is usually between 1-15% of the feed volume, to depress carbon formation from hydrocarbon cracking especially in the inlet of permreactor A.

37 Catalytic permreactor A can be any of the types of permreactors described in the embodiments of Fig.1, Fig.3, Fig.4, and Fig.5 above, with H_2 in the general case to be separated in permeate stream 1b via valve A1. H_2 and CO_2 gases combined can be separated in permeate stream 1b in special applications, if a suitable organic, inorganic, or composite membrane is used in permreactor A. The rejected exit stream from the permreactor may contain CO product together with unreacted steam ($\text{H}_2\text{O(g)}$), CO_2 , hydrocarbons, and non-permeate H_2 . This stream becomes stream 2 and enters into a heat exchanger B, wherein the unreacted steam is removed through condensation and by the heat exchanging process new steam is generated in stream 6 from the water or steam of stream 5. Stream 6, can provide steam in permreactor A and reactor E through streams 9 and 10,18 respectively, in an alternative or continuous manner via use of valves B1 and E1. The steam in stream 6 acquires the exchanged heat load from stream 2, the hot gas effluent of

reformer A, and thus its derived streams 9,10,18 can be mixed directly with streams 1 and 12 which are fed directly into reactors A and E respectively.

38 Steam from stream 6 is used via streams 10,18 and valves B1,E1 to provide the initial steam content in reformer E. Stream 7, passes through a bed of particles C (a moisture adsorbent) to remove any non-condensed traces of moisture and through the exit stream 8 enters into membrane permeator D. Stream 8, contains CO product, non-permeate H₂ product, unreacted hydrocarbon (e.g., CH₄) and CO₂ gases and has been cooled at the operating temperature of permeator D. H₂ or both H₂ and CO₂ are removed in permeate stream 11 of permeator D, through the permselective action of a metal, non-porous inorganic, polymeric or composite membrane respectively. Non permeating stream 12, containing hydrocarbons (e.g., CH₄), CO and CO₂ or hydrocarbons and CO respectively, depending on the type of membrane used in permeator D, exits from permeator D, through stream 12 as reject stream. Stream 12 enters into reformer E, for conducting simultaneously reforming and water shift reactions selected from the group of reactions (1), (2) and (3), and be converted into final products H₂, CO, CO₂ or H₂ and CO₂ only, depending on the feed composition of stream 12 in reformer E. Steam in reformer E is provided via stream 18. Unreacted steam is removed from exit stream 15 by passing this stream through a heat exchanger F. Steam is generated from water or steam of stream 16 and via streams 17,18 and valve E1, the generated steam is fed into the inlet of reformer E. Exit stream 19 contains H₂, CO, CO₂ or H₂, CO₂ products and traces of unreacted hydrocarbons, depending on the operating conditions, that is the temperature, pressure, space velocity and feed composition of

streams 12 and 18, of reformer E. Reformer E, can be replaced by a permeable reformer E similar to permeable reformer A, wherein H₂ is separated in permeate and the reject exit stream 19 consists of CO and CO₂ or of CO₂ only.

39 If conversion is high in permeable reformer A under certain operating conditions, the product in stream 2 is mainly CO and H₂ which can be used directly as synthesis gas in methanol synthesis via the direct exothermic reaction: CO+2H₂=CH₃OH, also in Fischer-Tropsch type reactions for production of gasoline type hydrocarbons, and as fuel in gas turbines, engines and solid oxide or molten carbonate fuel cells for power generation.

40 If the overall process consists of two reformers and the intermediate permeator, and the final product is a H₂ and CO₂ mixture in exit stream 19, it can be used separately or it can be mixed with stream 11 to make a combined H₂ and CO₂ stream. This combined H₂, CO₂ mixture can be used for direct methanol synthesis via the exothermic reaction (6), or formic acid synthesis via reaction (8). Also, the H₂, CO₂ mixture can be used as direct feed in molten carbonate fuel cells for electricity generation via the overall electrochemical reaction (13). Alternatively, CO₂ can be condensed cryogenically from the binary mixture and pure hydrogen can be produced. Final H₂ product can be used for chemical synthesis or as direct feed in fuel cells and gas turbines and engines for power generation applications (e.g., transportation, stationary). Applicable hydrogen driven fuel cells for utilizing the pure separated hydrogen from the process, include proton exchange membrane (PEM), solid oxide (SOFC), molten carbonate (MCFC), alkaline (AFC), phosphoric acid (PAFC) and modifications and combinations of these fuel cells. Generated

hydrogen product from streams 11b, 11, 19, can be combined with other chemical components in synthesis or combination type reactions as described above in Fig.1 and Fig.4.

41 The described process is able to overcome the thermodynamic equilibrium limitations of hydrocarbon (e.g., CH₄) and carbon oxide (e.g., CO₂) reactant conversion, through the removal of H₂ only, or of H₂ and CO₂ gases in permreactor A and permeator D. The calorific value of the obtained H₂, CO product in permreactor A, is higher than this of the reactant hydrocarbon (e.g., CH₄), CO₂ and steam and the endothermic heat of reaction is stored in the products which can be subsequently used as fuels or in chemical synthesis.

42 Assuming 100% conversion of reactions (1) and (2) and reaction (3) in equilibrium in permreactor A, 2 mol of CH₄ (with heat of combustion: 425.6 kcal), 1 mol of CO₂ (with no heat of combustion), and 1 mol of H₂O(g) (with no heat of combustion), produce 3 mol of CO (with heat of combustion: 202.8 kcal) and 5 mol of H₂ (with heat of combustion: 341.5 kcal). These values are at 25°C. This corresponds to about 28% increase in calorific value for the product. Endothermic heat can be provided in reformers A and E through flue or waste hot gases coming out of the interconnected fuel cells, turbines or engines and directed as input streams 3 and 13, as also described in Figs.1, 2, 3, 4, 5 above. Part of the exiting streams 2 and 15 can be also used to heat the reformers. The two reformers can operate at same or different temperature and pressure conditions.

43 In an alternative design, permeator D is replaced by a catalytic permreactor D wherein the water gas shift reaction occurs if stream 8 is rich in product CO. In

such a case permreactor D is made by metal, non-porous inorganic, or composite membranes to separate only product hydrogen in permeate stream 11. Exit reject stream 12 from permreactor D contains product CO₂ and unreacted steam and can be recycled in the first reforming permreactor A or used in downstream applications either as a mixture or as pure CO₂ after condensation of the steam.

44 [Fig.7, describes a similar embodiment with the one described in Fig.6, but feed stream 1 contains carbon monoxide (CO) only, mixed with steam, and introduced in catalytic permreactor A which is filled with catalyst particles to conduct the water gas shift reaction only.

Catalytic permeable water gas shift reactor A, is of any of the types described in embodiments of Figs. 1,2,3,4, and 5 above, with H₂ to be separated in permeate stream 1b via valve A1, in the general case. H₂ and CO₂ combined, can be separated in permeate stream for special applications, if an organic membrane is used in permreactor A. The rejected exit stream from the permreactor contains product CO together with unreacted steam (H₂O(g)) and non-permeate H₂. This stream becomes stream 2 and enters into heat exchanger B, where the unreacted steam is removed through condensation, and by the heat exchanging process new steam is generated in stream 6 from the water or steam of stream 5. Stream 6, can provide steam in permreactor A and reactor E through streams 4 and 11,13 respectively, in an alternative or simultaneous manner via use of valves B1,F1. The steam in 6 aquires the exchanged heat load from stream 2, the hot gas effluent of permeable reactor A, and thus its derived streams 4,11,13 can be mixed directly with streams 1 and 12 which are fed directly into reactors A and E respectively.

Steam from 6 is used via streams 11,13 and valve F1 to provide initial steam in reactor E. Stream 7 passes through a bed of particles (moisture adsorbent) C to remove any non-condensed traces of moisture and through exit stream 8 enters into membrane permeator D. Stream 8 contains non-permeate product H₂, product CO₂ and unreacted CO gases and has been cooled at the temperature of permeator D. H₂ and CO₂ are removed in permeate stream 9 through permselective action of membrane in permeator D. Non permeating CO exits from permeator through stream 10 which can be called a reject stream. Stream 10 can be recycled via valve D1 and stream 3 into the first permeable shift reactor A for continuous shift reaction and conversion to H₂ and CO₂ products. Alternatively, by use of same valve D1, stream 10 becomes 12 which enters into reactor E for additional shift reaction (2), and conversion to final H₂, CO₂ products. Steam in E is provided via stream 13. Unreacted steam is removed from exit stream 14 by passing this stream through heat exchanger F. New steam is generated from water or steam of stream 15 and via streams 16,13 and valve F1 is fed into inlet of reactor E. Exit stream 17 contains H₂, CO₂ products and traces of unreacted CO depending on the operating conditions, that is the temperature, pressure and feed composition of streams 12 and 13, of reactor E.

Shift reactors A and E are exothermic and no heat input is necessary as with the previous endothermic reformers described in previous embodiments. Stream 1 needs to be preheated in temperature of permeable reactor A before entering into reactor. Using the heat content of streams 2 and 14 exiting from the reactors to provide the necessary heat content in the feed streams 4 and 13 entering into the reactors, the entire process

operates in an autothermic way with no additional heat input necessary. The two shift reactors can operate at same or different temperature and pressure conditions.

Exit stream 17 can be used separately or it can be mixed with stream 9 to make a combined H₂ and CO₂ stream to be used for chemical synthesis or as fuel in applications similar to the ones mentioned above for the reforming reactors. Pure H₂ from the process can be recovered after the CO₂ condensation and removal. Pure hydrogen from the process, can be used as fuel or in chemical synthesis applications, as described in embodiment of Fig.6 above.

The described shift process is able to overcome the equilibrium CO reactant conversion limitations, through removal of H₂ in permreactor A and intermediate removal of H₂ and CO₂ products in permeator D. Thus, the process increases CO conversion and H₂, CO₂ yields above those obtained in conventional water gas shift reaction separation systems for production of H₂ and CO₂. By use of the two heat exchangers each shift reactor operates in an autothermic way with no need of additional heat load in the system except for the initial preheating of stream 1 to start-up operation in permreactor A.]

Fig.7, describes an embodiment of process similar to the one described in Fig.6, but the inlet stream 1 contains carbon monoxide (CO) only mixed with steam and introduced in catalytic permreactor A which is filled with catalyst particles to conduct the water gas shift reaction only.

45 Catalytic water gas shift permreactor A, can be any of the types of permreactors described in the embodiments of Fig.1, Fig.3, Fig.4, and Fig.5 above, with H₂ in the general case to be separated in permeate stream 1b via valve A1. H₂

and CO₂ gases combined can be separated in permeate stream 1b for special applications, if an organic, inorganic, or composite membrane is used in permreactor A. The rejected exit stream from the permreactor contains product CO together with unreacted steam (H₂O(g)) and non-permeate H₂. This becomes stream 2 and enters into a heat exchanger B, wherein the unreacted steam is removed through condensation, and by the heat exchanging process new steam is generated in stream 6 from the water or steam of stream 5. Stream 6, can provide steam in permreactor A and reactor E through streams 4 and 11, 13 respectively, in an alternative or continuous manner via use of valves B1,F1. The steam in 6 acquires the exchanged heat load from stream 2, the hot gas effluent of permeable reactor A, and thus its derived streams 4,11,13 can be mixed directly with streams 1 and 12 which are fed directly into reactors A and E respectively.

46 Steam from stream 6 is used via streams 11,13 and valve F1 to provide initial steam in reactor E. Stream 7 passes through a bed of particles (a moisture adsorbent) C to remove any non-condensed traces of moisture and through exit stream 8 enters into membrane permeator D. Stream 8 contains non-permeate product H₂, product CO₂ and unreacted CO gases and has been cooled at the temperature of permeator D. H₂ and CO₂ are removed in permeate stream 9 through permselective action of membrane in permeator D. Non permeating CO exits from permeator through stream 10 which can be called a reject stream. Stream 10 can be recycled via valve D1 as stream 3 into the first permeable shift reactor A for continuous shift reaction and conversion to H₂ and CO₂ products. Alternatively, by use of same valve D1, stream 10 becomes 12 which enters into reactor E for

additional water gas shift reaction, and conversion into final H₂, CO₂ products. Unreacted steam is removed from exit stream 14 by passing this stream through heat exchanger F. New steam is generated from water or steam of stream 15 and via streams 16,13 and valve F1 is fed into inlet of reactor E. Exit stream 17 contains H₂, CO₂ products and traces of unreacted CO depending on the operating conditions, that is the temperature, pressure, space velocity, and feed composition of streams 12 and 13 of reactor E.

47 Shift reactors A and E are exothermic and no heat input is necessary as with the previous endothermic reformers described in previous embodiments. Stream 1 needs to be preheated in temperature of permeable reactor A before entering into reactor. Using the heat content of streams 2 and 14 exiting from the reactors to provide the necessary heat content in the feed streams 4 and 13 entering into the reactors, the entire process operates in an autothermic way with no additional heat input necessary. The two shift reactors can operate at same or different temperature and pressure conditions.

48 Exit stream 17 can be used separately or it can be mixed with stream 9 to make a combined H₂ and CO₂ stream to be used for chemical synthesis or as fuel in applications similar to the ones mentioned in Fig.6. Pure H₂ from the process can be recovered after the CO₂ condensation and removal. Pure hydrogen from the process, can be used as fuel or in chemical synthesis applications, as described in embodiment of Fig.6 above.

49 The described shift process can overcome the equilibrium CO reactant conversion through removal of the H₂ in permreactor A and the intermediate

removal of H₂ and CO₂ products in permeator D. Thus, the process can increase the CO conversion and the H₂, CO₂ yields above the values obtained with conventional water gas shift reaction systems. By use of the two heat exchangers each shift reactor operates in an autothermic way with no need of additional heat load in the system except for the initial preheating of stream 1 to start-up operation in permreactor A.

50 [Fig.8 is an embodiment of a system of catalytic permreactor with consecutive permeator for conducting paraffin (alkane) dehydrogenation reactions. In Fig.8, stream 1 contains hydrocarbon feedstocks such as ethane, propane, n-butane, i-butane, naphtha, or liquid alkanes such as pentane, hexane, heptane. Liquid alkanes are vaporized by preheating before fed into catalytic permeable dehydrogenator A. Some hydrogen may be added into stream 1, which is usually between 1-15% of the feed volume, to depress carbon formation in the catalyst from hydrocarbon cracking especially in the inlet of permreactor A.

Catalytic permeable dehydrogenator A, is of any of the types described in embodiments of Figs. 1,2,3,4, and 5 above, with H₂ to be separated in permeate stream 1b via valve A1. The rejected exit stream from permreactor A contains unreacted paraffins, product olefins, and non-permeate hydrogen. This stream becomes stream 2 and optionally passes through heat exchanger B, where by the heat exchanging process steam is generated in stream 6 from the water or steam of stream 5 to be used in steam requiring applications.

Stream 7, enters into membrane permeator C. H₂ is removed in permeate stream 8 of permeator C, through the permselective action of a metal, non-porous inorganic, carbon or organic membrane. Non permeating stream containing hydrocarbons (product olefins and traces of unreacted paraffins) exits from permeator C, through stream 9 as reject stream. Stream 9 has composition dependent on the paraffin conversion in permreactor A and the hydrogen separation efficiency in permeator C. By optimizing these two parameters, pure olefins can be produced in stream 9, to be used as direct feed in polyolefin reactors E for polyolefin production (i.e., polyethylene, polypropylene) exiting from stream 10. Olefins from stream 9 are also used as direct feed in synthesis reactors, such as ethylene for ethylene oxide and ethylene glycol production, propylene for propylene oxide and propylene glycol production, isobutylene for oxygenated gasoline production. Produced pure hydrogen from the described process can be used into same fuel and synthesis applications as described in embodiment of Figs. 1 and 3.

Paraffin dehydrogenation reactions are endothermic, and reactor A receives heat from flue gas streams 3,4 to drive dehydrogenation reactions (4) to completion.

The described process is able to overcome the thermodynamic equilibrium limitations of paraffin hydrocarbon conversion met in conventional reactors, through the removal of product H₂ in membrane permreactor A and permeator C. Endothermic heat can be provided in dehydrogenator A through the combustion of flue or waste hydrocarbons or unreacted recycled hydrocarbons from the reaction zone of reactor A as also described in embodiments of Figs. 1,3 and 5 above.

Permeable dehydrogenator A can be substituted by non-permeable (e.g., non-porous stainless steel wall) dehydrogenator A. Valve A1 and stream 1b are eliminated

and all post-reaction gases exit from stream 2. Permeator C still operates in same function as described above.]

Fig.8 is an embodiment of a process of catalytic permreactor with consecutive permeator for conducting alkane (paraffin) dehydrogenation reactions. In Fig.8, stream 1 contains hydrocarbon feedstocks such as ethane, propane, n-butane, i-butane, naphtha, or liquid alkanes such as pentane, hexane, heptane. Liquid alkanes are vaporized by preheating before fed into the catalytic membrane dehydrogenator A. Some hydrogen may be added into stream 1, which is usually between 1-15% of the feed volume, to depress carbon formation in the catalyst from hydrocarbon cracking especially in the inlet of permreactor A.

51 **Catalytic permeable dehydrogenator A, can be any of the types described in embodiments of Figs.1, 3, 4, 5 above, with H₂ to be separated in permeate stream 1b via valve A1. The rejected exit stream from permreactor A contains unreacted paraffins, product olefins, and non-permeate hydrogen. This becomes stream 2 and optionally passes through a heat exchanger B, wherein by the heat exchanging process steam is generated in stream 6 from the water or steam of stream 5 to be used in steam requiring applications.**

52 **Stream 7, enters into membrane permeator C. H₂ is removed in permeate stream 8 of permeator C, through the permselective action of a metal, non-porous inorganic, composite, or polymeric membrane. Non permeating stream 9 containing hydrocarbons (product olefins and traces of unreacted paraffins) exits from permeator C as reject stream. Stream 9 has composition dependent on the paraffin conversion in permreactor A and the hydrogen separation efficiency in permeator C.**

By optimizing these two parameters, pure olefins can be produced in stream 9, to be used as direct feed in polyolefin production reactors E for polyolefin production (i.e., polyethylene, polypropylene) with the final polymer product to exit from stream 10. Olefins from stream 9 are also used as direct feed in synthesis reactors, such as ethylene for ethylene oxide and ethylene glycol production, propylene for propylene oxide and propylene glycol production, isobutylene for MTBE production used as blending in reformulated gasoline. Produced pure hydrogen from the described process can be used within the same fuel utilization and synthesis applications as described in embodiments of Figs.1 and 5. Paraffin dehydrogenation reactions are endothermic, and reactor A receives heat from flue gas streams 3,4 to drive dehydrogenation reactions (4) to completion.

53 The described process is able to overcome thermodynamic equilibrium limitations for paraffin conversion met in conventional reactors, through the removal of H₂ product in membrane permreactor A and permeator C. Endothermic heat can be provided in dehydrogenator A through the combustion of flue or waste hydrocarbons or unreacted recycled hydrocarbons from the reaction zone of reactor A as also described in embodiments of Figs.1,3,4, and 5 above.

54 Permeable dehydrogenator A can be substituted by a non-permeable (e.g., non-porous stainless steel wall) dehydrogenator A. Valve A1 and stream 1b are eliminated and all post-reaction gases exit from stream 2. Permeator C still operates with the same function as described above.

55 In an alternative process, permeator C can employ a specific polymer, polymer-metal, polymer-inorganic, polymer-metal-inorganic or composite

membrane for separation of the produced olefins from the unreacted paraffins. In this case the olefin rich stream exits via permeate stream 8, and the reject stream 9 rich in unreacted paraffins is recycled into permreactor A. Such membranes can be made by polymers, polymer composites, inorganic materials, dispersed or modified with metals such as copper (Cu), silver (Ag), zinc (Zn), chromium (Cr), cobalt (Co), nickel (Ni), tin (Sn), palladium (Pd), platinum (Pt), rhodium (Rh).

56 Fig.9, is [an] a process embodiment which is related with [these] those described in Figs.6 and 7, but with stream 1 to contain hydrocarbon feedstocks such as methane or higher alkanes such as naphtha and natural gas, also alcohol feedstocks such as methanol, ethanol, propanol, butanol mixed with steam only and introduced in catalytic permreactor A which is filled with catalyst particles to conduct the methane steam reforming reaction (1) and the simultaneously occurring water gas shift reaction [(2)] (3). Some hydrogen may be added into stream 1, which is usually between 1-15% of the feed volume, to depress carbon formation from hydrocarbon cracking especially in the inlet of [the reactor] permreactor A.

57 Catalytic [permeable reformer] permreactor A, [is of] can be any of the permreactor types described in embodiments of Figs. 1,2,3,4, [and] 5 above, with H₂ to be separated in permeate stream 1b via valve A1, in the general case. H₂ and CO₂ combined, can be separated in permeate stream 1b in special applications, if an organic, inorganic, or composite membrane is used in permreactor A. The rejected exit stream from the permreactor may contain product CO₂, CO, unreacted steam (H₂O(g)), [and] hydrocarbons, and non-permeate H₂. This stream becomes stream 2 and enters into heat

exchanger B, where the unreacted steam is removed through condensation, and by the heat exchanging process new steam is generated in stream 8 from the water or steam of stream 7. Stream 8, can provide steam in permreactor A and reactor E through streams 6 and 10,20 respectively, in an alternative or simultaneous manner via use of valves B1,E1. The steam in 8 acquires the exchanged heat load from stream 2, the hot gas effluent from permeable reformer A, and thus its derived streams 6,10,20 can be mixed directly with streams 1 and 14 which are fed directly into reactors A and E respectively.

Steam from 8 is used via streams 10,20 and valve E1 to provide initial steam in reformer E. Stream 9 passes through a bed of particles (moisture adsorbent) C to remove any non-condensed traces of moisture and through exit stream 11 enters into membrane permeator D. Stream 11 has been cooled in temperature of permeator D and contains CO, CO₂, unreacted hydrocarbon, non-permeate H₂ gas species.

58 H₂ or both H₂ and CO₂ are removed in permeate stream 12 of permeator D, through the permselective action of a metal, non-porous inorganic, [carbon] composite or organic membrane [respectively]. Non permeating stream 13 containing hydrocarbons (e.g., CH₄), CO and CO₂ or hydrocarbons and CO respectively, depending on the type of the membrane used in permeator D, exits from permeator D, through stream 13 as reject stream. In case wherein stream 13 contains hydrocarbons and carbon monoxide (CO) it can be recycled via valve D1 and stream 5 into first permeable reformer A for continuous reforming and conversion to main H₂ and CO₂ products. Alternatively, by use of valve D1, stream 13 becomes stream 14 which enters into steam reformer E for additional reforming and shift reactions, [via reactions (1) and (2)] (reactions (1), (3)), and [additional] conversion to H₂ and CO₂ products. In case wherein stream 13 contains

hydrocarbons, CO and CO₂, [using] by use of valve D1, stream 13 becomes stream 14 which enters into modified steam and CO₂ reformer E for additional reforming and shift reactions, via reactions (1), (2) and (3) and conversion to H₂, CO, CO₂ products. Reformer E, can be replaced by a permeable reformer E similar to permeable reformer A, wherein H₂ is separated in permeate and the reject exit stream 17 consists of product CO and CO₂ or CO₂ only.

59 Reformers A and E are endothermic and flue gas streams 3,4 and 15,16 respectively are used to provide the necessary heat content to drive parallel reactions (1), (2) and (3) to completion. The two reformers can operate at same or different reaction temperature and pressure conditions. If conversion is high in permeable [steam] reformer A under certain operating conditions, the product in stream 2 is mainly CO₂ and non-permeate H₂ which can be used directly in H₂, CO₂ applications described already in embodiment of Figs. 1 and [3] 4.

60 If the overall process [consists of two reformers] includes a second conventional reformer E and the intermediate permeator [,] as shown in Fig.9, and the final product is H₂ and CO₂ in exit stream 21, this product can be used separately or it can be mixed with stream 12 to make a combined H₂ and CO₂ stream to be used in similar applications. Alternatively, CO₂ can be condensed cryogenically from the binary mixture and pure hydrogen product [is] can be produced. Final H₂ product can be used for chemical synthesis or as direct feed in fuel cells, [and] gas turbines and engines for power generation applications (e.g., transportation, stationary), same to [these] those described in embodiments of [Fig.6] the previous figures. The waste flue streams coming out of

the interconnected fuel cells or engines, turbines, are used as streams 3 and 15 to heat the reformers A and E.

61 The described process is able to overcome [the] thermodynamic equilibrium limitations of hydrocarbon (e.g., CH₄) and steam reactant conversion, through the removal of H₂ product only, or of the combined H₂ and CO₂ products in membrane permreactor A and permeator D. The calorific value of the obtained H₂[,] and CO₂ products in permreactor A, is higher than this of the reactant hydrocarbon (e.g., CH₄) and steam mixture, because the provided endothermic heat of reaction is stored in the products and can be subsequently released by using products as fuels or in chemical synthesis.

62 Assuming 100% conversion of reactions (1) and [(2)] (3), 1 mol of CH₄ (with heat of combustion: 212.8 kcal) and 2 mol of H₂O(g) (with no heat of combustion) generate 1 mol of CO₂ (with no heat of combustion) and 4 mol of H₂ (with heat of combustion: 273.3 kcal). These values are at 25°C. This corresponds to about 28% increase in calorific value for the product gases. By providing external heat through flue or waste gas [input] combustion in the reformers or through internal stream recycling and with the described two heat exchangers in place, the energy requirement of the one reactor-one permeator or two reactor-one permeator cascades is fulfilled and [the] these processes operate[s] in a thermally independent manner providing for an energy efficient design. Endothermic heat can be provided also in reformers A and E [through] via the combustion of [flue or waste gases or unreacted recycled hydrocarbons] exit or recycled streams from the reaction zone of reformers A and E (streams 9, 13, 21), as also described in [Figs.1,3,5] Figs.1,2,3,4,5 above.

63 [Fig.10, is an embodiment of a steam and CO₂ hydrocarbon reforming process which includes a permeable reformer or a non-permeable reformer followed by a cryogenic separator for separation of certain post-reaction gases exiting from the reject exit of the reformer. In Fig.10, stream 1 is introduced into catalytic permreactor A, containing hydrocarbon feedstocks such as methane (CH₄) mixed with steam and CO₂ for conducting simultaneously reactions (1), (2) and (3), or mixed with CO₂ only for conducting reactions (2) and (3). Some hydrogen may be added into stream 1, which is usually between 1-15% of the feed volume, to depress carbon formation from methane cracking especially in the inlet of permreactor A.

Catalytic permeable reformer A, is of any of the types described in embodiments of Figs. 1,2,3,4, and 5 above, with H₂ to be separated from the reformer, and exit in permeate stream 1b via valve A1. The rejected exit stream from the permreactor contains product CO together with unreacted steam (H₂O(g)), CO₂, and hydrocarbon, and non-permeate H₂. This stream becomes stream 2 and enters into a steam condenser C wherein the unreacted steam is condensed and by the heat exchanging process new steam is generated in steam 17 from the water or steam of stream 16. Steam through stream 17 is recycled into stream 1 in inlet of reformer A. Stream 5 free of steam, exits from condenser C and enters into cryogenic separator B, which operates at a temperature lower than the boiling temperature of carbon dioxide and hydrocarbons so that these compounds are separated as liquids and collected in the bottom of the separator (operating cryogenic temperature of the separator is a negative number which has larger absolute value than the absolute value of any of the boiling points of the liquified

components above). However, operating cryogenic temperature of separator is higher than the boiling points of carbon monoxide and hydrogen so that these compounds remain in the gas phase and exit from the separator as a gas mixture (operating cryogenic temperature of the separator is a negative number which has smaller absolute value than the absolute value of the boiling points of both hydrogen and carbon monoxide). Liquified components exit via stream 7 through valve B1. Gas phase hydrogen and carbon monoxide exit as stream 6 via valve B2. Liquified stream 7 can be recycled into the feed stream of reformer A (stream 1) via stream 8 after evaporation in evaporator D. Alternatively, stream 8 can be further processed in another reforming reactor by becoming stream 9 which enters into reformer E, for additional steam and CO₂ reforming of any remaining hydrocarbons via reactions (1), (2) and (3). Optional, steam in reformer E is provided via stream 18. Stream 10 exiting the reformer can optionally condense the containing unreacted steam by passing through the heat exchanger F. Inlet stream 11 contains water which becomes steam in stream 12 after passing through F. Steam in stream 12 can optionally fed into reformer E via valve E1. Stream 13 exiting the heat exchanger F is dry, and contains H₂ and CO as main products with traces of unreacted hydrocarbons and CO₂ depending on the operating temperature and pressure of the reformer E and the composition of feed streams 10 and 12.

Recovered H₂ and CO in stream 13 can be either used separately or optionally be combined with stream 6 from the separator to make one stream to be used as fuel or in chemical synthesis. Direct application of the produced H₂ and CO mixture is in methanol synthesis via the direct exothermic reaction: CO+2H₂=CH₃OH, also in Fischer-Tropsch type reactions for production of gasoline type hydrocarbons, and as fuel in gas turbines

and engines and solid oxide fuel cells for power generation. Similarly, H₂ recovered in stream 5, can be used as fuel or in chemical synthesis, as described in embodiment of Fig.6. The described process is able to overcome the thermodynamic equilibrium limitations of hydrocarbon (e.g., CH₄), steam and CO₂ reactant conversion, through the removal of H₂ and H₂ and CO gases in membrane permreactor A and cryogenic separator B respectively. Endothermic heat in reformers A and E is provided through gas streams 3,4 and 14,15 respectively. Streams 3, 14 can be fed by a bypass stream of exit stream 2, as also described in embodiments of Figs.1,3,5. The reformer A can be optionally substituted by a non-permeable reformer A, wherein stream 1b and valve A1 are eliminated and all product H₂ is included in post-reaction mixture entering through stream 2 into cryogenic separator B.]

Fig.10, is a new embodiment of a steam and CO₂ hydrocarbon reforming process which includes a permeable reformer or a non-permeable reformer followed by a cryogenic separator for separation of certain post-reaction gases exiting from the reject exit of the reformer. In Fig.10, stream 1 is introduced into catalytic permreactor A, containing hydrocarbon feedstocks such as methane (CH₄) mixed with steam and CO₂ for conducting simultaneously reactions (1), (2) and (3), or mixed with CO₂ only for conducting reactions (1) and (2). Some hydrogen may be added into stream 1, which is usually between 1-15% of the feed volume, to depress carbon formation from methane cracking especially in the inlet of permreactor A.

64 **Catalytic permeable reformer A, is of any of the types described in embodiments of Figs. 1,2,3,4, and 5 above, with H₂ to be separated from the reformer, and exit in permeate stream 1b via valve A1. The rejected exit stream**

from the permreactor contains product CO together with unreacted steam ($H_2O(g)$), CO_2 , and hydrocarbon, and non-permeate H_2 . This becomes stream 2 and enters into a steam condenser C wherein the unreacted steam is condensed and by the heat exchanging process new steam is generated in steam 17 from the water or steam of stream 16. Steam through stream 17 is recycled into stream 1 in inlet of reformer A. Stream 5 free of steam, exits from condenser C and enters into cryogenic separator B, which operates at a temperature lower than the boiling temperature of carbon dioxide and hydrocarbons so that these compounds are separated easily as liquids and collected in the bottom of the separator (the operating cryogenic temperature of the separator is a negative number which has larger absolute value than the absolute value of any of the boiling points of the liquified components above). However, the operating cryogenic temperature of separator is higher than the boiling points of carbon monoxide and hydrogen so that these compounds remain in gas phase and exit from the separator as a gas mixture (operating cryogenic temperature of the separator is a negative number which has smaller absolute value than the absolute value of the boiling points of both hydrogen and carbon monoxide). Liquified components exit via stream 7 through valve B1. Gas phase hydrogen and carbon monoxide exit as stream 6 via valve B2. Liquified stream 7 can be recycled into the feed stream of reformer A (stream 1) via stream 8 after evaporation in evaporator D. Alternatively, stream 7 can be further processed in another reforming reactor by becoming stream 9 which enters into reformer E, for additional steam and CO_2 reforming of any remaining hydrocarbons via reactions (1), (2) and (3). Optionally, steam in reformer E is provided via stream 18 which is a bypass stream of stream 17.

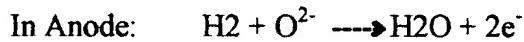
Stream 10 exiting the reformer can optionally condense the containing unreacted steam by passing through the heat exchanger F. Inlet stream 11 contains water which becomes steam in stream 12 after passing through F. Steam in stream 12 can optionally be fed into reformer E via valve E1. Stream 13 exiting the heat exchanger F is dry, and contains H₂ and CO as main products with traces of unreacted hydrocarbons and CO₂ depending on the operating temperature and pressure of the reformer E and the composition of feed streams 9 and 12.

65 Recovered H₂ and CO in stream 13 can be either used separately or optionally be combined with stream 6 from the separator to make one stream to be used as fuel in conventional and fuel cell systems or in chemical synthesis. Direct application of the produced H₂ and CO mixture is in methanol synthesis via the direct exothermic reaction: CO+2H₂=CH₃OH, also in Fischer-Tropsch type reactions for production of gasoline type hydrocarbons, as fuel in gas turbines and engines and in solid oxide and molten carbonate fuel cells for power generation. Similarly, H₂ recovered in stream 1b, can be used as fuel or in chemical synthesis, as described in previous embodiments.

66 The described process is able to overcome the thermodynamic equilibrium limitations of hydrocarbon (e.g., CH₄), steam, and CO₂ reactant conversion, through the removal of H₂ and H₂ and CO gases in membrane permreactor A and cryogenic separator B respectively. Endothermic heat in reformers A and E is provided through gas streams 3,4 and 14,15 respectively. The waste heat from the fuel cell or the conventional engine, turbine is used to provide the heat in reformers A and E via flue streams 3 and 14 respectively. Streams 3, 14 can be also fed by a bypass stream

of exit stream 2, as also described in embodiments of the previous figures. The reformer A can be optionally substituted by a non-permeable reformer A, wherein stream 1b and valve A1 are eliminated and all product H₂ is included in post-reaction mixture entering through the stream 2 into cryogenic separator B.

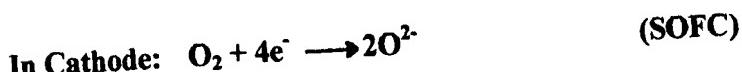
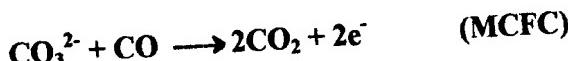
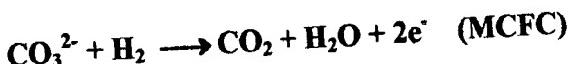
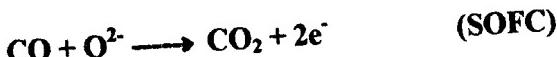
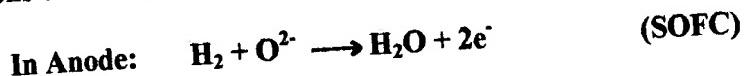
67 [Fig.11, is a modified embodiment of the process described in Fig.6. It applies to complete conversion of hydrocarbon (i.e., CH₄) and CO₂ reactants of stream 1, within the permeable reformer A, to H₂ and CO products. The occurring reactions are (1),(2),(3) or (2),(3) only. Catalytic permeable reformer A, is of any of the types described in embodiments of Figs. 1,2,3,4, and 5 above, with H₂ to be separated in permeate stream 3 via valve A1. Exiting from the permreactor, stream 2, containing only CO and non-permeating H₂, or CO, non-permeating H₂, and traces of unreacted steam, enters into a solid oxide fuel cell (SOFC) unit B. Stream 2 is directed in the anode of the solid oxide cell, and consists the fuel constituent of the fuel cell. O₂ in stream 4, is directed in the cathode of the fuel cell and consist the oxidant, for the well known electrochemical reaction conducted within the cell with electric current generation:



Optionally, part of hydrogen from permeate stream 3, can be fed into stream 2, via bypass stream 3b, to adjust the composition of H₂ in stream 2 to that required to feed the fuel cell B. The reformer A can be optionally substituted by a non-permeable reformer A, wherein all product H₂ is included in exit stream 2. Flue gas streams 5 and 6, are used to provide the endothermic heat content into the reformer A. Stream 5 can be fed by a

bypass stream of exit stream 2, as also described in embodiments of Figs.1,3,5. Permeable reformer A can be substituted by a non-permeable (e.g., stainless steel) reformer A. Valve A1 and stream 3, 3b are eliminated and all post-reaction gases exit reformer A. Valve A1 and stream 3, 3b are eliminated and all post-reaction gases exit from stream 2. Fuel cell B still operates in same function as described above.]

Fig.11, is a modified embodiment of the process described in Fig.6. It applies to a complete conversion of hydrocarbons (e.g., CH_4) and CO_2 reactants of stream 1, within the permeable reformer A, to H_2 and CO products. The occurring reactions are (1),(2),(3) or (1),(2) only. Catalytic permreactor A, can be any of the types described in embodiments of Figs. 1,3,4 and 5 above, with H_2 to be separated in permeate stream 3 via valve A1. The exiting from the permreactor, stream 2, containing only CO and non-permeating H_2 , or CO, non-permeating H_2 , and traces of unreacted steam, enters into a solid oxide (SOFC) or molten carbonate (MCFC) fuel cell which is unit B. Stream 2 is directed in the anode of the fuel cell, and makes the fuel constituent of the fuel cell. Stream 4 consists of O_2 or air for SOFCs, and of $\text{CO}_2\text{-O}_2$, or CO_2 -air mixtures for MCFCs respectively, and is directed in the cathode of the fuel cell B. Stream 4 is therefore the oxidant, for the known electrochemical reactions conducted within the two cells for electric current generation:





68 Optionally, part of hydrogen from permeate stream 3, can be fed into stream 2, via bypass stream 3b, to adjust the composition of H₂ in stream 2 to that required to feed the fuel cell B. Flue gas streams 5 and 6, are used to provide the endothermic heat content into the reformer A. Stream 5 can be fed by a bypass stream of exit stream 2, as also described in embodiments of Figs.1,3,4,5. Moreover, stream 7 which is the flue gas from the fuel cell, can be also directed into stream 5 to make the hot flue gas for heating the reformer A. Reformer A can be optionally substituted by a non-permeable reformer A, wherein all catalytically produced H₂ is contained into the exit stream 2. Valve A1 and streams 3 and 3b are eliminated and all post-reaction gases exit from stream 2. Fuel cell B still operates in same function as described above with flue gas stream 7 from the fuel cell to heat the reformer A.

69 [Fig.12, is an embodiment which describes a modified operation of the process described in Fig.6. It applies to complete conversion of hydrocarbon (i.e., CH₄) and CO₂ reactants of stream 1, within the permeable reformer A, to H₂ and CO products. The occurring reactions within the reformer are (1),(2),(3) or (2),(3) only. Catalytic permeable reformer A, is of any of the types described in embodiments of Figs. 1,2,3,4, and 5 above, with H₂ to be separated in permeate stream 1b via valve A1. Exiting from the permreactor, stream 2, containing only CO and non-permeating H₂, or CO, non-permeating H₂, and traces of unreacted steam, passes through heat exchanger B and moisture adsorbent C to remove unreacted steam, and enters into permeator D as a dry stream. Hydrogen is separated in stream 11 from carbon monoxide, rejected by the

membrane, and exiting via stream 12. Carbon monoxide, via stream 12, can be optionally fed into a consecutive water gas shift reactor E for conversion to final H₂ and CO₂ products. A heat exchanger F is used in exit of the water gas shift reactor E, to remove any unreacted steam, with final stream 15 to contain only H₂ and CO₂. The reformer A can be optionally substituted by a non-permeable reformer A, wherein all reaction product H₂ is included in exit stream 2 and stream 1b, valve A1 are eliminated.

Hydrogen from stream 11 can be used in applications mentioned already in embodiment described in Fig.6 and Fig.9. Similarly CO from stream 12, or H₂ and CO₂ from stream 15 can be used in aforementioned applications described already in embodiments of Figs.6,9 and 10.]

Fig.12, is a modified embodiment of the process described in Fig.6. It pertains to methanol production from the products of the reforming reaction occurring in permreactor A, and the subsequent utilization of methanol in a methanol fuel cell. The process describes the complete conversion of hydrocarbons (e.g., CH₄) and CO₂ reactants, in stream 1, within the permeable reformer A, into H₂ and CO products. The occurring reactions are (1),(2),(3) or (2),(3) only. Catalytic permeable reformer A, can be any of the types described in embodiments of Figs. 1,3,4, and 5 above, with H₂ to be separated in permeate stream 1b via valve A1. The exiting from the permreactor, stream 2, containing only CO and non-permeating H₂, or CO, non-permeating H₂, and traces of unreacted steam, passes through heat exchanger B and moisture adsorbent C to remove unreacted steam and result in an all dry stream of H₂ and CO. Stream 8, of H₂ and CO products (synthesis gas) enters into the

methanol synthesis reactor D, wherein methanol is produced via the following exothermic reaction:



70 Reactor D, can be a slurry type reactor or a catalytic plug flow reactor with methanol to be produced in gas or liquid phase depending on the temperature, pressure and feed composition into the reactor and the type of catalyst used. Zinc, copper and chromium oxide catalysts are well known to convert synthesis gas to methanol. Methanol from stream 9 can be fed into a methanol driven fuel cell for electricity generation or for further use as a synthesis chemical including the synthesis of higher hydrocarbons.

71 Optionally, stream 1c, which is a bypass stream of stream 1b and contains pure hydrogen, can be recycled into stream 8 via stream 16 to adjust hydrogen composition in this stream where necessary, and to increase the efficiency of methanol synthesis in reactor D. Product hydrogen from stream 1b can be used in fuel, fuel cell, and synthesis applications. Reformer A is endothermic and flue gas streams 3,4 are used to provide the necessary heat content to drive parallel reactions (1), (2), (3) to completion. The waste or flue gas from the interconnected methanol fuel cell can be used to provide the heat content in stream 3 to heat the reformer A. Stream 3 can be also fed by a bypass stream of stream 2. Optionally, reformer A can be a non-permeable reformer with only one post-reaction outlet (exit), this of stream 2, which delivers all products and unreacted reactants into the heat exchanger B and next into methanol reactor D.

72 [Fig.13, is an embodiment of a modified process of the process described in Fig.6.

It pertains to methanol production from the products of the reforming reaction occurring in reactor A, and the subsequent utilization of methanol in a methanol-steam reforming reactor. The process describes the complete conversion of hydrocarbon (i.e., CH₄) and CO₂ reactants, in stream 1, within the permeable reformer A, to H₂ and CO products. The occurring reactions are (1),(2),(3) or (2),(3) only. Catalytic permeable reformer A, is of any of the types described in embodiments of Figs. 1,2,3,4, and 5 above, with H₂ to be separated in permeate stream 1b via valve A1. Exiting from the permreactor, stream 2, containing only CO and non-permeating H₂, or CO, non-permeating H₂, and traces of unreacted steam, passes through heat exchanger B and moisture adsorbent C to remove unreacted steam and yield an all dry stream of H₂ and CO. Stream 8, of H₂ and CO (synthesis gas) enters into the methanol synthesis reactor D, wherein methanol is produced via the following exothermic reaction: CO+2H₂=CH₃OH, ΔH°₂₉₈=-128.2kJ/mol (13.1). Reactor D, is a three phase slurry type reactor or a catalytic plug flow reactor with methanol to be produced in gas or liquid phase depending on the temperature, pressure and feed composition in the reactor and the type of catalyst used. Zinc, copper and chromium oxide catalysts are well known to convert synthesis gas to methanol. Methanol from stream 9 is fed to a methanol driven fuel cell for electric current generation. Optionally, stream 9 containing methanol enters into steam reforming reactor E for continuous catalytic methanol-steam reforming reaction in similar type catalysts. The reforming reaction in reactor E is as follows: CH₃OH+H₂O=3H₂+CO₂, ΔH°₂₉₈=49.5kJ/mol (13.2). Exiting from the reactor E, gaseous stream 11, condenses

unreacted steam and methanol in heat exchanger F, and the exit product gas through stream 14 is H₂ and CO₂. Steam in reactor E is provided through streams 6,10,13,20 which is generated by the heat exchanging process in heat exchangers B and F.

Pure H₂ and CO₂ mixture from exit stream 14, can be used as feed in molten carbonate fuel cells or in alternative methanol synthesis via the opposite reaction of methanol steam reforming, listed above. Optionally, bypass streams 15, 16 can be fed into stream 8 to add CO₂ and H₂ into the synthesis gas mixture fed into reactor D, to adjust its composition for increasing methanol production efficiency in the catalyst in reactor D via the reverse (13.2) reaction. Optionally also, stream 1c, which is a bypass stream of stream 1b and contains pure hydrogen, can be recycled into stream 8 via stream 16, for adjusting the hydrogen composition in this stream where necessary, to increase the efficiency of methanol synthesis in reactor D. Streams 15 and 1c merge into stream 16 via valve D1.

Hydrogen in stream 14 can be used as a mixture with CO₂, or as pure H₂ after the CO₂ condensation and removal.

Produced hydrogen from streams 1b and 14, can be used in applications mentioned already in embodiments described in Fig.6 and Fig.9. The H₂ and CO₂ mixture of stream 14 can be used in synthesis or fuel applications mentioned already in same embodiments. Reformers A and E are endothermic and flue gas streams 3,4 and 18,19 respectively are used to provide the necessary heat content to drive parallel reactions (1), (2), (3) and (13.2) respectively to completion. Streams 3 and 18 can be fed by a bypass stream of stream 2. Optionally, reformer A can be a non-permeable reformer with only

one post-reaction outlet (exit), this of stream 2, which delivers all products and unreacted reactants into the heat exchanger B and next into reactor D.]

Fig.13, is a modified embodiment of the process described in Fig.4. It shows a cross section of a similar concentric double wall permreactor, consisting of an outer impermeable tube, a next-inner and a most-inner membrane tubes with the two later ones to be made by metal, inorganic, or composite membranes to be used for hydrogen permeation. Hydrogen is generated by conducting dehydrogenation reactions and steam, CO₂ reforming type reactions within the catalyst located in the central annular zone (7). Also, pure hydrogen or diluted hydrogen with inerts such as argon or nitrogen may flow along the zone (7). Two additional catalytic zones (4) and (5) are created by filling the space between outer and next-inner tubes and within the most inner tube with suitable metallic catalyst. The corresponding exothermic hydrogenation reactions take place in the catalyst located in zones (4) and (5) by utilizing the permeate hydrogen. The central annular zone (7) may include tubular type heaters (6) running along the axial direction to provide heat for the endothermic reactions occurring within the zone.

73 The same modified double membrane reactor structure can be applied to the oxidation of methane and to the methane oxidative coupling reactions for production of synthesis gas or higher hydrocarbons respectively. In this case, both membrane tubes (2) and (3) are made by porous or nonporous solid oxide, oxygen ion-conducting materials which are permeable to oxygen or air. Oxygen or air are flowing along the central annular zone (7). Oxygen or air permeate via membrane tubes (2) and (3) and react with methane flowing along zones (4) and (5) to make the

final oxidation products. Zones (4) and (5) are catalytic, filled with suitable metal and metal oxide catalysts to conduct the exothermic oxidative reactions. Hydrogen and carbon monoxide are the products from the methane oxidation reaction, while C₂ hydrocarbons are produced from the oxidative coupling of methane. The central annular zone (7) is empty in this case because only oxygen or air is flowing through, and no heating or heaters are required within the zones (4), (5), (7) because the oxidative reactions are exothermic. Oxidation catalysts include nickel, rhodium, platinum, palladium, ruthenium, while oxidative coupling catalysts include La₂O₃, MgO, PbO, Li₂O. The synthesis gas produced can be fed in conventional and fuel cell power systems or used in chemical synthesis reactions as described in previous embodiments. C₂ hydrocarbons such as ethane and ethylene can be used in chemical synthesis or as fuel blending.

74 The processing permreactor described in Fig.13 can be used in multiple modules which can be placed symmetrically inside a larger impermeable tube to create a multiple tube processing reactor with a common external area similar to the one shown in Fig.5. This type of multiple process configuration is able to process large amounts of reacting feedstocks and to produce larger throughputs of product mixtures in comparison with the single module processing permreactor in Fig.13. The lateral sectional view of the processing permreactor described in Fig.13 is similar with this of Fig.2 with the exception that the tubular type heaters for the dehydrogenation-hydrogenation coupling reactions are located in the central annular zone (7) between the membrane tubes (2) and (3).

Abstract of the Disclosure

75 [Overall permreactor-separator process designs and effective permreactor designs with increased mass and heat transfer, reactant conversion, product yield and optional recycling for processing methane, hydrocarbons, alcohols, carbon monoxide, natural gas, acidic natural gas, coal gas, biomass gas, and mixtures of hydrocarbons with carbon dioxide, based on the reforming reactions of these feedstocks with steam and carbon dioxide and the dehydrogenation reactions of saturated hydrocarbons. Final exit streams from these gas phase processors contain pure hydrogen, hydrogen and carbon monoxide mixture, hydrogen and carbon dioxide mixture, and can be used as a direct feed in molten carbonate, solid oxide, proton exchange membrane, alkaline, phosphoric acid and other types of hydrogen driven fuel cells. Same final exit processed streams can be alternatively used for direct chemical synthesis such as methanol, for hydrogenations and hydrogen based reduction reactions such as those of unsaturated hydrocarbons to paraffins, and as feed in power generation systems such as gas turbines and gas engines.]

Overall permreactor-separator (or membrane reactor-separator) processes with integration of reaction and separation in one unit, increased mass and heat transfer, increased reactant conversion and product yield with internal stream recycling, for the processing and conversion of methane, higher hydrocarbons, alcohols, carbon monoxide, natural gas, coal gas, landfill gas, biomass gas, and other flue, waste mixtures of methane or higher hydrocarbons with carbon dioxide, based on reforming reactions of these feedstocks with steam and/or carbon dioxide; also for dehydrogenation reactions of hydrocarbons, and for methane oxidation reactions.

Final exit streams from the gas phase processors contain pure hydrogen or synthesis gas (hydrogen and carbon monoxide, hydrogen and carbon dioxide mixtures), and can be used as direct feed in molten carbonate, solid oxide, proton exchange membrane, alkaline, phosphoric acid and other types of hydrogen driven fuel cells. The same final exit processed streams can be alternatively used for direct chemical synthesis in a variety of reactions such as methanol and gasoline synthesis, for various hydrocracking, hydrogenations, and hydrogen based reduction and synthesis reactions, and as feed in power generation systems such as gas turbines, gas engines, and various types of fuel cells.



Marked-up Version of Amended Claims (Includes amended claims).

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Inventors: S. Vasileiadis, Z. Ziaka-Vasileiadou

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Deleted Matter is shown in brackets, e.g., [membrane reactor]

Added matter is shown in bold letters e.g., **permreactor and separator**

1. (amended) A [reactor which is used as a] **process for conducting catalytic steam and CO₂ hydrocarbon reforming, steam-alcohol reforming, water gas shift, and dehydrogenation [reactor, which consists of] reactions for production and use of hydrogen and synthesis gas which includes:**

a far-outer impermeable hollow tubular cylinder which nests two more concentric [hydrogen] permeable tubular cylinders, having the inner permeable one to be nested within the outer permeable, with the inner permeable cylinder to be filled with catalyst particles[, with] **and include** tubular type heaters [to be] located **along the axis**, [within the catalyst zone, and run parallel to the inner cylindrical axis,] with the catalyst in pellet or particle form to be a reforming, water gas shift or dehydrogenation catalyst depending on the **type of feedstocks** fed in the inlet of the reactor and the type of reactions conducted within the catalytic zone, [moreover] **further**, with hydrogen to be removed via permeation along the inner membrane tube, wherein the membrane is made by a metal, metal alloy, non-porous inorganic or metal-inorganic or [carbon] composite material, **which also act as catalysts for the reactions**, with carbon monoxide, carbon dioxide, steam, hydrocarbons, alcohols and non-permeate hydrogen to be rejected by the membrane and exit through the main outlet of the inner tube, with the permeate hydrogen

to be diluted by a carrier gas flowing along the [annulus] **annular zone** between [the] inner and outer permeable tubes and [to be] further removed [through] via permeation along the outer permeable membrane tube, wherein the outer membrane is made by a metal, **metal alloy**, non-porous inorganic [,] or **metal-inorganic** or [carbon] composite material, so that second [permeated] **permeate** stream contains pure hydrogen only, with the annular space between the outer membrane tube and the far-outer impermeable tube which receives final permeate hydrogen to contain a selective catalyst, wherein permeate hydrogen reacts with a sweep component flowing through the inlet of this annular space [, parallel to the outer membrane tube,] in an exothermic type reaction [,] and produces a product which exits via a separate outlet located by the end of the outer annular zone, with the membranes to act also as catalysts for the reactions, with the heat generated by the exothermic reaction in the most-outer catalytic zone to be transferred via the radial direction into the main catalytic reaction zone of the inner membrane tube thus providing for part of the heat load necessary to drive the endothermic catalytic reactions [in] **within** the inner membrane tube, with the main heating load of this inner [catalytic] zone to be achieved via heat transfer from **the inner gas tubes** [flowing gas, arranged symmetrically around the reactor axis and operated] which operate in the combustion regime by flowing waste **or flue** type hydrocarbons or hydrocarbon-hydrogen mixtures mixed with oxygen or air, [also] and by flowing unreacted hydrocarbons, **alcohols** and carbon monoxide post-reaction species, and any of their mixtures, **which** are exiting from the inner membrane tube outlet and recovered in the downstream of the reactor [through various] by **use of** separation processes including [separation through] **membrane separation** [permeation,] and by having these **fuel gas** mixtures to be recycled

[as fuel] into the inlet of [these] the heating tubes to support combustion and heat provision in the surrounding inner catalytic zone, and finally with the sweep reactive component, which reacts with the hydrogen permeated [from] via the outer membrane tube, to be one of the following:

an unsaturated hydrocarbon such as an alkene or alkyne for hydrogenation to a saturated or less unsaturated hydrocarbon, such as ethane, propane, butane, or ethylene, propylene, butylene,

[also to be] carbon monoxide for hydrogenation to methanol or gasoline hydrocarbons,

[also to be] nitrogen for hydrogenation to ammonia,

a paraffin such as hexane for hydrocracking to a mixture of paraffins and olefins with a lower carbon atom, such as butane, propane, propylene, ethylene,

[also to be] an aromatic hydrocarbon for reduction with hydrogen to a non-aromatic hydrocarbon,

[also to be] an unsaturated alcohol, phenol, aldehyde, ketone, or acid for reduction with hydrogen to a corresponding saturated component,

an aldehyde or ketone for reduction with hydrogen to the corresponding alcohol such as methanol, ethanol, propanol, butanol,

[also to be] an alkyl or aryl halide for reduction with hydrogen to a corresponding non-halogen component [,] via hydrogenolysis,

[also to be] a nitroalkane or aromatic nitro compound for reduction with hydrogen to a corresponding primary amine.

2. (amended) The [reactor assembly and] process of claim 1, wherein the annular space enclosed between the outer permeable membrane tube and the far-outer impermeable metal tube is empty and the permeate pure hydrogen through outer membrane tube is used as feed in various consecutive applications including hydrogenation [reactors] **reactions** for methanol, gasoline hydrocarbons, and ammonia synthesis, also as **fuel** in gas turbines, engines, and fuel cells of proton exchange membrane, alkaline, molten carbonate, solid oxide and phosphoric acid types, **with the emitted flue gas from the fuel cells, turbines and engines to be used for heating the reformer by flowing via the inner gas tubes.**

3. (amended) The process of claim 1 wherein the inner membrane tube is made by a porous inorganic, [or] inorganic-metal **or composite** membrane material with hydrogen to permeate through the membrane, and carbon monoxide, carbon dioxide, steam, reactant and product hydrocarbons and alcohols to permeate also through the membrane in a lesser degree, with hydrogen only to permeate through the outer [metal, non-porous inorganic or carbon] membrane tube and with the remaining non-permeate species to exit through the reject outlet of the annular space created between the two membrane tubes either as it is mixture or after mixing with another carrier gas flowing through the same annular space, with the permeate pure hydrogen through the outer membrane to be used as feed in various consecutive applications including hydrogenation [reactors] **reactions** for methanol, gasoline hydrocarbons and ammonia synthesis, also as **fuel** in gas turbines, engines, and fuel cells of proton exchange membrane, alkaline,

molten carbonate, solid oxide and phosphoric acid types, with the emitted flue gas from the fuel cells, turbines or engines to be used for heating the reformer by flowing via the inner gas tubes.

4. (amended) The process of claim 1 as applied to carbon dioxide hydrocarbon reforming and dehydrogenation reactions, wherein the inner membrane tube is made by a porous inorganic, [or] inorganic-metal **or composite membrane** material with hydrogen to permeate through the membrane, and carbon monoxide, carbon dioxide, reactant and product hydrocarbon species, to permeate also through the membrane in a lesser degree, and with the outer membrane tube to be made by an organic, **inorganic, or composite** polymer membrane which withstands high temperatures and is permselective to both hydrogen and carbon dioxide species, with hydrogen and carbon dioxide [in] for the reforming reaction [case] or hydrogen only [in] **for** the dehydrogenation [case] **reaction**, to permeate through the outer membrane, and with the remaining non-permeate species to exit through the reject outlet of the annular space created between the two membrane tubes, either as it is mixture or after mixing with another carrier gas flowing through the same annular space, with the permeate through the outer membrane hydrogen and carbon dioxide mixture to be used for methanol, **formic acid, or methane** synthesis and as feed in molten carbonate fuel cells, and in [the corresponding] case wherein hydrogen only is the permeate through [the outer membrane tube, the permeate hydrogen] **same membrane** to be used as feed in various consecutive applications including hydrogenation [reactors] **reactions** for methanol, gasoline hydrocarbons, and ammonia synthesis, also as fuel in gas turbines, engines, and fuel cells of proton

exchange membrane, alkaline, molten carbonate, solid oxide and phosphoric acid types, with the emitted flue gas from the fuel cells, turbines or engines to be used for heating the reformer by flowing via the inner gas tubes.

5. (amended) A [reactor which is used as a] process for conducting catalytic steam and CO₂ hydrocarbon reforming, steam-alcohol reforming, water gas shift, and dehydrogenation [reactor,] reactions for production and use of hydrogen and synthesis-gas which [consists of] includes:

a most outer non-permeable tubular cylinder which is hollow in the center and nests two more concentric hollow membrane tubular cylinders, a next-inner one and a most-inner one, which are both made by permeable materials with the annular space between most-outer and next-inner cylinders to contain a metallic catalyst in the form of pellets or particles, with the catalyst to be a reforming, water gas shift or dehydrogenation catalyst depending on the feedstocks fed in the inlet of the annular catalytic zone and the type of reactions conducted within the catalytic zone, with the next-inner cylinder to nest also a concentric most-inner hollow membrane cylinder, with next-inner cylinder to be made by a metal, metal alloy, non-porous inorganic, or [carbon] composite membrane [material] which is permeable only to hydrogen, and acts also as catalyst for the reactions, with product hydrogen from the catalytic reaction zone to permeate through the lateral membrane surface of next-inner cylinder, with carbon monoxide, carbon dioxide, steam, hydrocarbons, alcohols and non-permeate hydrogen to be rejected by the next-inner membrane and exit through outlet fitting ports located by the end of the catalytic zone, with permeate hydrogen flowing along the annular zone between next-

inner and most-inner cylinders to be diluted by a carrier gas flowing along the same [annulus] **annular space** and [to be] further removed via permeation across the most-inner permeable membrane tube, wherein most-inner membrane tube is made by metal, metal-alloy, non-porous inorganic or [carbon] composite materials, so that secondly permeated stream flowing inside most-inner membrane tube contains only pure hydrogen, with the most-inner membrane tube to contain a selective catalyst in form of particles or pellets, wherein permeate hydrogen reacts with a sweep component flowing through [an] the inlet port of the most-inner membrane tube in an exothermic type reaction [,] and produces a product which exits via a separate outlet located by the end of the most inner cylinder, with the membranes to act also as catalysts for the reactions, with the heat generated by the exothermic reaction [in the most-inner catalyst zone] to be transferred into the main catalytic reaction zone enclosed between most-outer and next-inner hollow cylinders, thus providing for part of the heat load necessary to drive the endothermic catalytic reactions occurring in this zone, with the main heating of the overall cylindrical assembly and of main catalytic zone to be achieved by heat transfer coming from combustion of gases, including combustion of waste or flue type hydrocarbons and hydrocarbon-hydrogen mixtures mixed with oxygen or air, also of unreacted hydrocarbons and carbon monoxide post-reaction species and any of their mixtures exiting from the corresponding [reaction] outlet port of the outer cylinder [, which are] and recovered in the downstream of the reactor [through various] by use of separation processes including [separation through] membrane separation [permeation, and] and by having these gas mixtures to be recycled as fuel gas flowing along the external side of [the] most-outer impermeable cylinder to support combustion and heat

provision in enclosed main catalytic zone, **and finally** with the sweep reactive component which reacts with the hydrogen permeated [in] via the most-inner membrane tube, to be **one of the following:**

an unsaturated hydrocarbon such as an alkene or alkyne for hydrogenation to a saturated or less unsaturated hydrocarbon, such as ethane, propane, butane, or ethylene, propylene, butylene,

[also to be] carbon monoxide for hydrogenation to methanol or gasoline hydrocarbons,

[also to be] nitrogen for hydrogenation to ammonia,

a paraffin such as hexane for hydrocracking to a mixture of paraffins and olefins with a lower carbon atom, such as butane, propane, propylene, ethylene,

[also to be] an aromatic hydrocarbon for reduction with hydrogen to a non-aromatic hydrocarbon,

[also to be] an unsaturated alcohol, phenol, aldehyde, ketone, or acid for reduction with hydrogen to a corresponding saturated component,

an aldehyde or ketone for reduction with hydrogen to the corresponding alcohol such as methanol, ethanol, propanol, butanol,

[also to be] an alkyl or aryl halide for reduction with hydrogen to a corresponding non-halogen component [,] via **hydrogenolysis**,

[also to be] a nitroalkane or aromatic nitro compound for reduction with hydrogen to a corresponding primary amine.

6. (amended) The [reactor assembly and] process of claim 5, wherein most inner membrane tube is empty and the pure permeate hydrogen within this tube is used as feed in various consecutive applications including hydrogenation [reactors] **reactions** for methanol, gasoline hydrocarbons, and ammonia synthesis, also **as fuel** in gas turbines, engines, and fuel cells of proton exchange membrane, alkaline, molten carbonate, solid oxide and phosphoric acid types, **with the emitted flue gas from the fuel cells, turbines or engines to be used for heating the reformer by flowing around the external surface.**

7. (amended) The process of claim 5 wherein next-inner [hollow] **membrane** cylinder is made by a porous inorganic or inorganic-metal **or composite** membrane, with hydrogen to permeate through the membrane, and carbon monoxide, carbon dioxide, steam, reactant and product hydrocarbons [,] **and** alcohols, to permeate also through the membrane in a lesser degree, with hydrogen only to permeate through the most-inner [metal, metal alloy, non-porous inorganic, or carbon] membrane tube and with the remaining non-permeate species, to exit through the reject outlet of the annular space created between the next-inner and most-inner cylinders, either as it is mixture or after mixing with another carrier gas flowing through the same annular space, with the permeate through the inner membrane tube, pure hydrogen product, to be used as feed in various consecutive applications including hydrogenation [reactors] **reactions** for methanol, gasoline hydrocarbons and ammonia synthesis, also **as fuel** in gas turbines, engines, and fuel cells of proton exchange membrane, alkaline, molten carbonate, solid oxide and phosphoric acid types, **with the emitted flue gas from the fuel cells, turbines**

or engines to be used for heating the reformer by flowing around the external surface.

8. (amended) The process of claim 7, as applied to carbon dioxide hydrocarbon reforming and dehydrogenation reactions only, wherein the most-inner membrane tube is made by an organic, **inorganic, or composite** polymer membrane which withstands high [temperatures] **temperature** and is permselective to both hydrogen and carbon dioxide species [.] which permeate through the most-inner membrane tube, with the remaining non-permeate species to exit through the reject outlet of the annular space created between the next-inner and most-inner membrane tubes [,] either as it is mixture or after mixing with another carrier gas flowing through the same annular space, with the permeate through the most-inner membrane tube hydrogen and carbon dioxide mixture to be used for methanol, **formic acid, or methane** synthesis [and] or as feed in molten carbonate fuel cells, and in [corresponding] **reaction-permeation** case wherein hydrogen only permeates through the most-inner membrane tube, [the] permeate hydrogen [to be] is used as feed in various consecutive applications including hydrogenation [reactors] **reactions** for methanol, gasoline hydrocarbons, and ammonia synthesis, [also] **and as** fuel in gas turbines, engines, and fuel cells of proton exchange membrane, alkaline, molten carbonate, solid oxide and phosphoric acid types, **with the emitted flue gas from the fuel cells, turbines or engines to be used for heating the reformer by flowing around the external surface.**

37. (amended) The process of claim [12] 19 wherein the membrane permeator following the permeable reformer is replaced by a cryogenic separator, which operates at a cryogenic subzero temperature of absolute value higher than the condensation temperature of the unreacted steam, hydrocarbons, carbon dioxide, and lower than the condensation temperature of carbon monoxide and hydrogen, with the hydrogen and carbon monoxide gases to be separated as gases from the cryogenic separator, and with the steam, hydrocarbons and carbon dioxide to be separated as condensed liquids, with these liquified components to be continuously or periodically reheated by use of an immersed or surrounding heater to the section of the separator containing the liquified phase, and to be exited from the separator by use of a special **open-close** valve, and be recycled into the inlet of the reforming reactor for continuous **conduction of the** steam and carbon dioxide reforming and water gas shift reaction in the reformer, with the separated hydrogen and carbon monoxide mixture from the cryogenic separator to be used in following applications:

- a) methanol synthesis,
- b) gasoline synthesis via Fischer-Tropsch synthesis route,
- c) as combustion fuel **or as combustion fuel blending** in gas turbines and gas engines,
- d) as fuel in solid oxide fuel cells,
- e) **as fuel in molten carbonate fuel cells,**

either as it is mixture, or after mixing with all or part of the hydrogen stream permeated from the permeable reformer, **with the emitted flue gas from the fuel cell to be used for heating the reformer.**

39. (amended) The process of claim 11 wherein the membrane permeator following the permeable reformer is replaced by a cryogenic separator, which operates at a cryogenic subzero temperature of absolute value higher than the condensation temperature of the unreacted steam, hydrocarbons, **alcohols**, carbon dioxide, and lower than the condensation temperature of carbon monoxide and hydrogen, with the hydrogen and carbon monoxide gases to be separated as gases from the cryogenic separator, and with the steam, hydrocarbons and carbon dioxide to be separated as condensed liquids, with these liquified components to be continuously reheated by use of an immersed or surrounding heater to the section of the separator containing the liquified phase, and to be exited from the separator by use of a special **open-close** valve, and be [entered] fed into the inlet of a consecutive reforming reactor for continuous steam, [and] carbon dioxide reforming, and water gas shift [reaction] **reactions** in the reformer and conversion into final H₂ and [CO₂] CO products, having the exit stream from the last reforming reactor to condense its unreacted steam by passage through a heat exchanger and by generating new steam in the other side of the heat exchanger to be used as additional steam feed in the inlet of [this] **the** last reforming reactor in an autothermic type **of** operation, having the final exit dry mixture of [H₂ and CO₂] **hydrogen and carbon monoxide** from last heat exchanger to be used [as direct feed in a methanol synthesis reactor and molten carbonate fuel cell unit, also in other
chemical synthesis and
fuel type reactions

either as it is mixture or after the CO₂ condensation and removal, as pure hydrogen, moreover with the separated hydrogen and carbon monoxide mixture from the cryogenic separator to be used] in the following applications [,] :

- a) methanol synthesis,
- b) gasoline synthesis via Fischer-Tropsch synthesis route,
- c) as combustion fuel or as combustion fuel blending in gas turbines and gas engines,
- d) as fuel in solid oxide fuel cells,
- e) as fuel in molten carbonate fuel cells,

either as it is mixture, or after mixing with part or all of the **separated hydrogen and carbon monoxide gas stream exiting from the cryogenic separator and with part or all of the hydrogen stream permeated from the first permeable reformer, finally with the emitted flue gas from the fuel cell to be used for heating at least one reformer.**

40. (amended) The process of claim [5] 7 as applied to the carbon dioxide and steam reforming of hydrocarbons or carbon dioxide only reforming of hydrocarbons, **including methane as a hydrocarbon**, wherein complete conversion of hydrocarbons and carbon dioxide occurs in the permeable reformer and the reject exit stream from the reformer consists only of hydrogen, [and] carbon monoxide products and unreacted [and produced] steam, which exit [reject] rejected stream enters as a fuel feed [in] into a solid oxide fuel cell unit or into a molten carbonate fuel cell unit for [electric current] electricity or power generation, **and with part or all of the permeate hydrogen coming out of the separate permreactor exit to be recycled into the reject exit stream from the**

**permreactor, in order to [complement] provide for additional hydrogen fuel entering
into the [fuel cell] solid oxide or molten carbonate fuel cells, with the emitted flue gas
from the fuel cell to be used for heating the reformer.**